-1520-237-23-8

TM 55-1520-237-23-8

TECHNICAL MANUAL

AVIATION UNIT AND INTERMEDIATE MAINTENANCE
FOR
ARMY
UH-60A AND EH-60A HELICOPTERS

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This copy is a reprint which includes current pages from Change 1.

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This TM supersedes TM 55-1520-237-23-1, dated 15 November 1988, TM 55-1520-237-23-2, TM 55-1520-237-23-4, TM 55-1520-237-23-5, TM 55-1520-237-23-6, TM 55-1520-237-23-7, TM 55-1520-237-23-8, TM 55-1520-237-23-9, TM 55-1520-237-23-10, dated 29 December 1978, and TM 55-1520-237-23-11, dated 13 May 1985.

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NO. 1

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WASHINGTON, D.C., 22 November 1989

Aviation Unit and Aviation Intermediate Maintenance Manual

FOR

ARMY UH-60A, EH-60A AND UH-60L HELICOPTERS

TM 55-1520-237-23-8, 29 August 1989, is changed as follows:

1. Title has been changed to read as stated above.

2. Remove and insert pages as indicated below. New or changed text material is indicated by a vertical bar in the margin. An illustration change is indicated by a miniature pointing hand.

Remove pages	Insert pages
H-3 and H-4	H-3 and H-4
H-103 through H-106	H-103 through H-106
H-271 and H-272	H-271 and H-272
Index-15 and Index-16	Index-15 and Index-16
Index-21 and Index-22	Index-21 and Index-22
Index-37 and Index-38	Index-37 and Index-38
Index-65 and Index-66	Index-65 and Index-66
Index-79 and Index-80	Index-79 and Index-80
Index-83 and Index-84	Index-83 and Index-84
Index-93 and Index-94	Index-93 and Index-94
- - - -	Index 94.1/94.2

3. Retain this sheet in front of manual for reference purposes.

By Order of the Secretary of the Army:

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Chief of Staff

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APPENDIX G

WEIGHT AND BALANCE

Refer to AR 95-16, TM 55-1500-342-23, and TM 55-1520-237-10.

APPENDIX H

ILLUSTRATED FIELD MANUFACTURE ITEMS LIST

H-1. ILLUSTRATED FIELD MANUFACTURE ITEMS LIST.

H-2. Introduction. This appendix includes complete instructions for making items authorized to be manufactured or fabricated at aviation unit maintenance (AVUM) or aviation intermediate maintenance (AVIM). Individual illustrations for these items include simplified line drawings and supporting text containing all instructional data needed to make the item. Bulk material used in the fabrication of these items are listed by part number, material classification and National Stock Number (NSN). Each illustration includes the part number of the item to be fabricated.

H-3. Part Number Index. The part number index lists all items in alphanumerical order with a cross-reference to the figure in which the item appears.

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70500-02066-212	H-171	70500-02066-258	H-170
70500-02066-213	H-171	70500-02066-259	H-171
70500-02066-214	H-170	70500-02066-260	H-171
70500-02066-215	H-171	70500-02066-261	H-171
70500-02066-216	H-171	70500-02066-262	H-171
70500-02066-217	H-171	70500-02066-263	H-170
70500-02066-218	H-170	70500-02066-264	H-171
70500-02066-219	H-170	70500-02066-265	H-170
70500-02066-220	H-170	70500-02066-266	H-170
70500-02066-221	H-170	70500-02066-267	H-170
70500-02066-222	H-171	70500-02066-268	H-171
70500-02066-223	H-170	70500-02066-269	H-171
70500-02066-224	H-171	70500-02066-270	H-171
70500-02066-225	H-170	70500-02066-271	H-171
70500-02066-226	H-170	70500-02066-272	H-170
70500-02066-227	H-170	70500-02066-273	H-171
70500-02066-228	H-170	70500-02066-274	H-170
70500-02066-229	H-170	70500-02066-275	H-170
70500-02066-230	H-170	70500-02066-276	H-170
70500-02066-231	H-171	70500-02066-277	H-170

Part Number Index (Cont)

Part No.	Figure No.	Part No.	Figure No.
70500-02066-278	H-171	70500-02073-107	H-129
70500-02066-279	H-171	70500-02073-108	H-129
70500-02066-280	H-171	70500-02076-101	H-132
70500-02066-281	H-171	70500-03050-108	H-81
70500-02066-282	H-171	70500-03050-153	H-81
70500-02066-283	H-171	70500-03050-113	H-79
70500-02066-284	H-171	70500-03050-114	H-78
70500-02066-285	H-171	70500-03050-115	H-80
70500-02066-286	H-171	70500-03050-130	H-155
70500-02066-287	H-171	70500-03050-151	H-79
70500-02066-288	H-171	70500-03050-153	H-81
70500-02066-289	H-171	70500-03050-154	H-78
70500-02066-290	H-171	70500-03050-165	H-15
70500-02066-291	H-171	70550-01125-108	H-1
70500-02066-292	H-171	70550-01126-106	H-3
70500-02066-293	H-171	70550-01126-107	H-3
70500-02066-294	H-171	70550-02151-101	H-97
70500-02066-295	H-171	70550-02151-102	H-97
70500-02066-296	H-170	70551-07000-103	H-103
70500-02066-297	H-170	70651-03102-180	H-41
70500-02066-298	H-170	70651-03102-181	H-41
70500-02066-299	H-171	70651-03102-182	H-41
70500-02066-300	H-171	70652-02251-170	H-41
70500-02066-301	H-171	70652-02251-171	H-41
70500-02066-302	H-171	70652-02251-172	H-41
70500-02068-109	H-126	70652-02251-173	H-41
70500-02068-118	H-89	70652-02251-174	H-41
70500-02068-121	H-126	70652-02251-175	H-41
70500-02068-123	H-102	70652-02251-177	H-41
70500-02068-124	H-127	70652-02251-178	H-41
70500-02070-108	H-131	70652-02251-179	H-41
70500-02070-109	H-93	70652-02251-180	H-41
70500-02070-111	H-92	70652-02252-149	H-44
70500-02070-118	H-92	70652-02252-172	H-44
70500-02071-109	H-117	70652-02252-174	H-44
70500-02071-110	H-117	70652-02252-175	H-44
70500-02071-111	H-94	70652-02252-176	H-44
70500-02072-107	H-96	70652-03252-143	H-44
70500-02072-108	H-96	70652-03252-146	H-44
70500-02072-109	H-133	70652-03252-149	H-44
70500-02072-110	H-134	70652-03252-153	H-44
70500-02073-101	H-109	70652-03252-158	H-44
70500-02073-106	H-129	70652-03252-159	H-44

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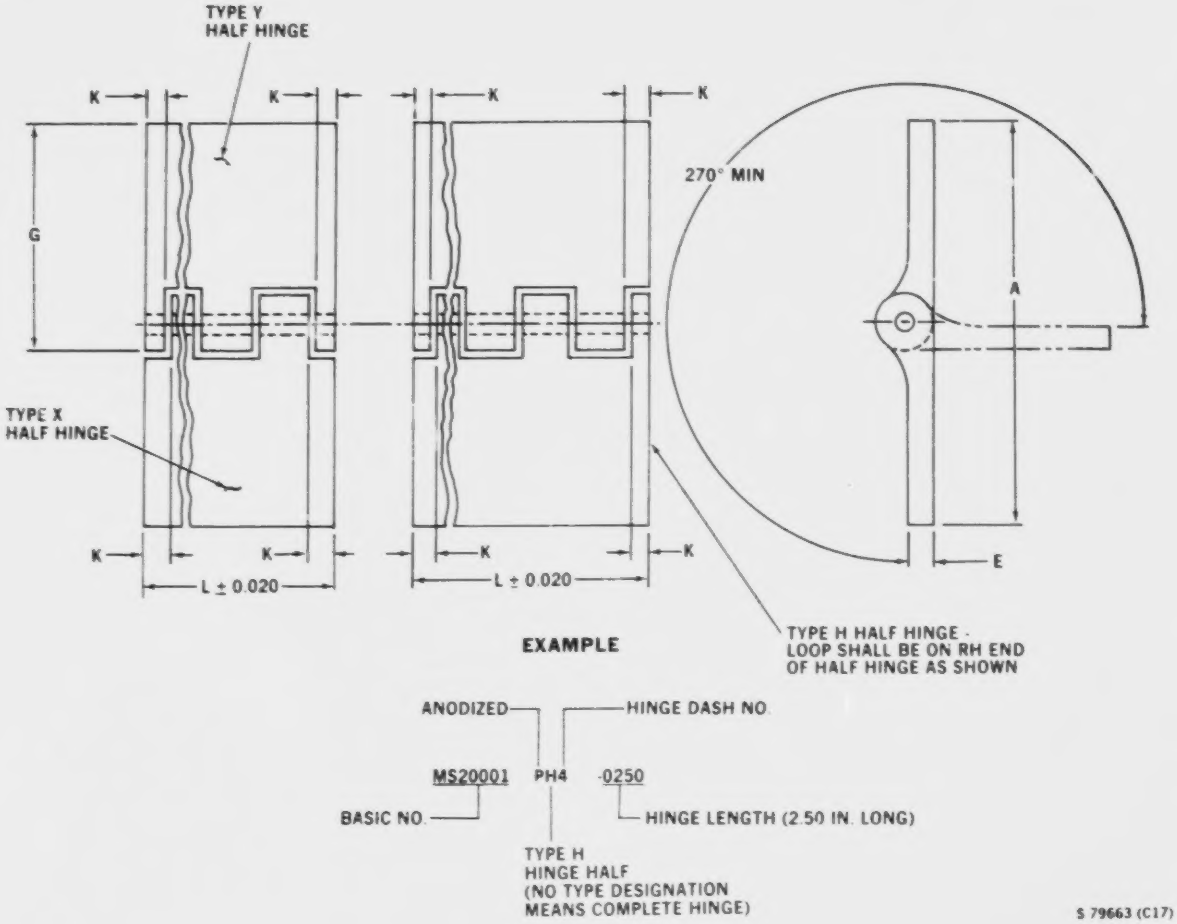
70652-03252-161	H-44
70652-05251-141	H-44
70652-05251-143	H-44
70652-05251-144	H-44
70652-05251-145	H-44
70652-05251-148	H-44
70652-05251-149	H-44
70700-20014-110	H-161
70700-20313-104	H-138
70700-20313-105	H-139
70700-20313-106	H-100
70700-20313-107	H-100
70700-20313-108	H-100
70700-20313-118	H-160
70700-20313-119	H-160
70700-20324-105	H-110
70700-20325-101	H-154
70700-20325-102	H-154
70700-20325-103	H-154
70700-20325-104	H-154
70700-20325-105	H-154
70700-20325-106	H-154
70700-20325-107	H-154
70700-20325-108	H-157
70700-20369-102	H-29
70700-20395-107	H-98
70700-20395-108	H-98
70700-20420-116	H-99
70700-20426-118	H-149
70700-20460-103	H-42
70700-20507-104	H-29
70700-20507-105	H-107
70700-20508-102	H-29
70700-20509-103	H-29
70700-20509-104	H-24
70700-20511-106	H-33
70700-20511-107	H-33
70700-20511-108	H-33
70700-20511-109	H-33
70700-20511-110	H-33
70700-20511-111	H-33
70700-20511-112	H-33
70700-20511-113	H-33
70700-20511-114	H-33
70700-20511-115	H-33
70700-20511-116	H-33
70700-20511-117	H-33
70700-20511-118	H-33
70700-20511-119	H-42
70700-20511-121	H-42
70700-20512-103	H-29
70700-20512-106	H-29
70700-20514-103	H-29
70700-20515-102	H-29
70700-20515-104	H-29
70700-20677-102	H-145
70700-20677-103	H-145
70700-20680-108	H-20
70700-50005-108	H-60
70700-50005-113	H-61


TYPE Y
HALF HINGE
K
K
K
K
G
270° MIN
A
TYPE X
HALF HINGE
K
K
K
K
L ± 0.020
L ± 0.020
E
EXAMPLE
TYPE H HALF HINGE - LOOP SHALL BE ON RH END OF HALF HINGE AS SHOWN
ANODIZED
HINGE DASH NO.
MS20001
PH4
-0250
BASIC NO.
HINGE LENGTH (2.50 IN. LONG)
TYPE H
HINGE HALF
(NO TYPE DESIGNATION
MEANS COMPLETE HINGE)
S 79663 (C17)

DASH NO.	A WIDTH OPEN	E	G HALF HINGE SIZE		K	PIN DIA
			MAX	MIN	MIN	
4	1.500	0.056	0.850	0.830	0.188	0.090
5	1.750	0.056	0.975	0.955	0.188	0.090
6	2.000	0.056	1.102	1.078	0.188	0.090

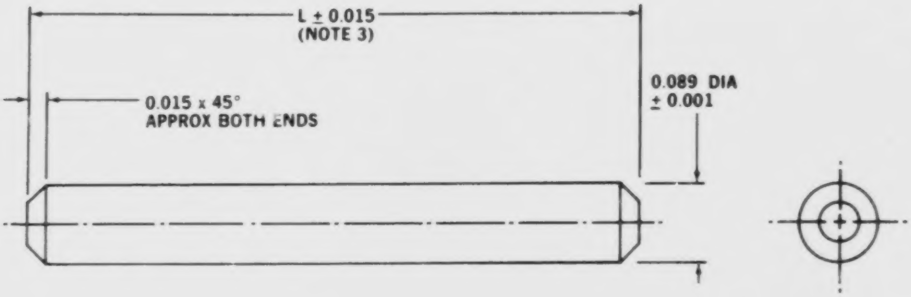
FIGURE H-1. HINGE (SHEET 1 OF 2)

HINGE PART NUMBER	MAKE FROM — NSN	SIKORSKY PART NUMBER
MS20001PH4-0250	5340-00-949-8274	70215-05002-120
MS20001PX4-0450	5340-00-949-8274	70217-03006-114
MS20001PY4-0450	5340-00-984-5569	70217-03006-113
MS20001-PH4-1200	5340-00-949-8274	70215-05002-117
MS20001-PH4-1200	5340-00-949-8274	70215-05002-118
MS20001-PH4-1200	5340-00-949-8274	70215-05002-119
MS20001PY4-1984	5340-00-984-5569	—
MS20001PX4-1984	5340-00-949-8274	70550-01125-108
MS20001P4-600	5340-00-664-8141	70212-05004-118
MS20001P4-0375	5340-00-664-8141	—
MS20001P4-600	5340-00-664-8141	70217-03002-111
MS20001P4-1012	5340-00-664-8141	70217-03001-108
MS20001P4-1012	5340-00-664-8141	70217-03001-109
MS20001P5-600	5340-00-550-5036	70217-03002-112
MS20001P5-0980	5340-00-550-5036	70308-03504-111
MS20001P5-0980	5340-00-550-5036	70308-03504-112
MS20001P5-1000	5340-00-550-5036	—
MS20001P6-1950	5340-00-664-8118	70215-42409-114
MS20001P6-1950	5340-00-664-8118	70215-42409-115

NOTES:

1. MAKE FROM MS20001 ALUMINUM ALLOY HINGE STOCK.
2. TYPE X HINGE HALF MATES WITH TYPE Y HINGE HALF. TYPE H IS INTERCHANGEABLE WITH BOTH TYPES OF HINGE HALVES.
3. HINGE PINS ARE PER MS20253. USE CADMIUM PLATED CORROSION RESISTANT STEEL PINS WITH ALUMINUM ALLOY HINGE.
4. REMOVE ALL BURRS AND SHARP EDGES.
5. ALL DIMENSIONS ARE IN INCHES.
6. TREAT CUT EDGES WITH CORROSION RESISTANT COMPOUND (ALODINE) MIL-C-5541, NSN 8030-00-811-3723.
7. INK-STAMP "MS20001-(SIZE DASH NO.)" AT REGULAR INTERVALS ALONG LENGTH OF HINGE SO THAT ANY 3-INCH LENGTH WILL HAVE AT LEAST ONE COMPLETE IDENTIFICATION IN FIGURES NOT LESS THAN 0.060 INCH HIGH.

FIGURE H-1. HINGE (SHEET 2 OF 2)



S 79664 (C17)

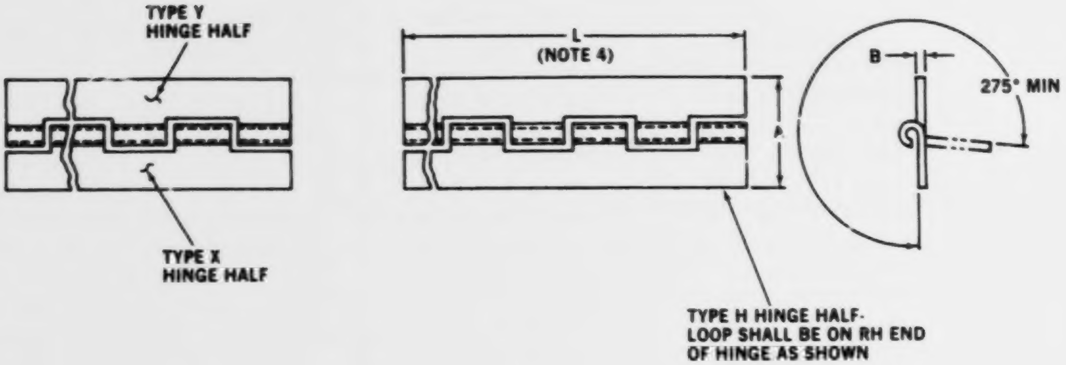
HINGE PIN PART NUMBER	LENGTH (L)	SIKORSKY PART NUMBER
MS20253P2-250	2.250	–
*MS20253P2-275	2.750	70215-05002-128
MS20253P2-0475	4.750	–
MS20253P2-500	5.000	–
MS20253P2-538	5.380	–
MS20253P2-1200	12.000	–
**MS20253P2-1225	12.250	70215-05002-129
MS20253P2-1984	19.840	–
MS20253P2-2050	20.500	–

*ON INSTALLATION, STAKE FRONT END OF PIN.
**ON INSTALLATION, STAKE REAR END OF PIN.

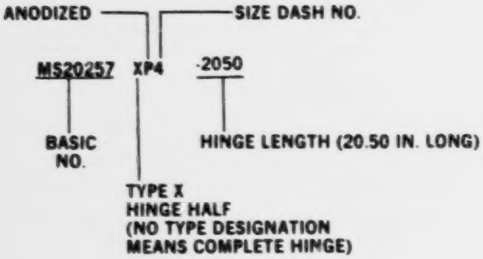
NOTES:

1. MAKE FROM MS20253P2 HINGE PIN STOCK, NSN 5340-00-043-3723.
2. LETTER P IN FIRST DASH NUMBER INDICATES CADMIUM PLATE. NUMBER 2 IN FIRST DASH NUMBER INDICATES PIN DIAMETER (0.089).
3. SECOND DASH NUMBER INDICATES LENGTH IN INCHES AND HUNDREDTHS.
4. ALL DIMENSIONS ARE IN INCHES.
5. IDENTIFY PARTS PER MIL-STD-130.
6. CUT PIN TO REQUIRED LENGTH PER CHART AND FINISH ENDS AS SHOWN.
7. REMOVE ALL BURRS AND SHARP EDGES.
8. FOR USE WITH MS20001 AND MS20257 ALUMINUM ALLOY HINGE, AS REQUIRED.
9. STAKE PINS, AS REQUIRED, PER TM 55-1500-204-25/1.

FIGURE H-2. HINGE PIN


TYPE Y
HINGE HALF
TYPE X
HINGE HALF
L
(NOTE 4)
A
B
275° MIN
TYPE H HINGE HALF-
LOOP SHALL BE ON RH END
OF HINGE AS SHOWN

EXAMPLE


ANODIZED
SIZE DASH NO.
MS20257 XP4 -2050
BASIC
NO.
HINGE LENGTH (20.50 IN. LONG)
TYPE X
HINGE HALF
(NO TYPE DESIGNATION
MEANS COMPLETE HINGE)

S 79665 (C17)

DASH NO.	A WIDTH OPEN	B THICK-NESS	PIN DIA
1	0.750	0.032	0.063
2	1.062	0.040	0.090
3	1.250	0.040	0.090
4	1.500	0.040	0.090
5	2.000	0.051	0.090

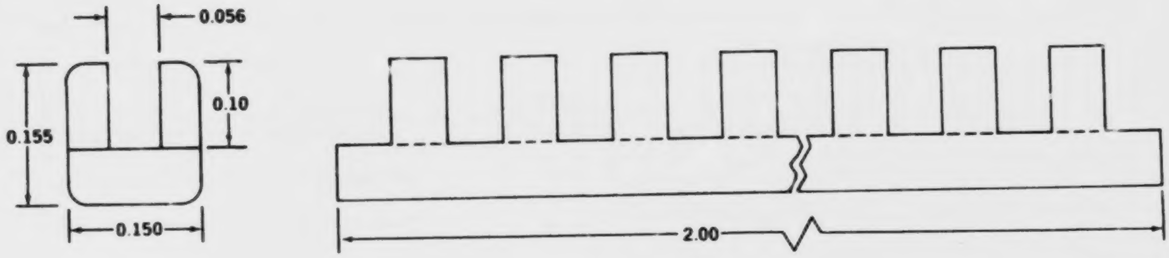
FIGURE H-3. HINGE (SHEET 1 OF 2)

HINGE PART NUMBER	MAKE FROM NSN	SIKORSKY PART NUMBER
MS20257HP3-0500	5340-00-051-9132	70205-06053-105
MS20257HP3-0500	5340-00-051-9132	70205-06053-106
MS20257XP4-2050	5340-00-051-9133	–
MS20257YP4-2050	5340-00-051-9133	–
MS20257XP5-2050	5340-00-069-5124	70550-01126-106
MS20257YP5-2050	5340-00-069-5124	70550-01126-107
MS20257-1-0550	5340-00-057-2625	–
MS20257P2-0350	5340-00-250-4970	–
MS20257P2-0400	5340-00-250-4970	–
MS20257P3-250	5340-00-051-9132	–
MS20257P3-0300	5340-00-051-9132	70219-04802-117
MS20257P3-900	5340-00-051-9132	–
MS20257P3-1200	5340-00-051-9132	–
MS20257P3-1462	5340-00-051-9132	–
MS20257P3-1500	5340-00-051-9132	–
MS20257P4-600	5340-00-051-9133	–

NOTES:

1. MAKE FROM MS20257 ALUMINUM ALLOY HINGE STOCK.
2. TYPE X HINGE HALF MATES WITH TYPE Y HINGE HALF. TYPE H IS INTERCHANGEABLE WITH BOTH TYPES (X AND Y) HINGE HALVES.
3. HINGE PINS ARE PER MS20253. USE CADMIUM PLATED CORROSION RESISTANT STEEL PIN WITH ALUMINUM ALLOY HINGE.
4. REMOVE ALL BURRS AND SHARP EDGES.
5. ALL DIMENSIONS ARE IN INCHES.
6. TREAT CUT EDGES WITH CORROSION RESISTANT COMPOUND (ALODINE) MIL-C-5541, NSN 8030-00-811-3723.
7. INK STAMP "MS20257-(SIZE DASH NO.)" AT REGULAR INTERVALS ALONG LENGTH OF HINGE SO THAT ANY 3-INCH LENGTH WILL HAVE AT LEAST ONE COMPLETE IDENTIFICATION IN FIGURES NOT LESS THAN 0.060 INCH HIGH.

FIGURE H-3. HINGE (SHEET 2 OF 2)

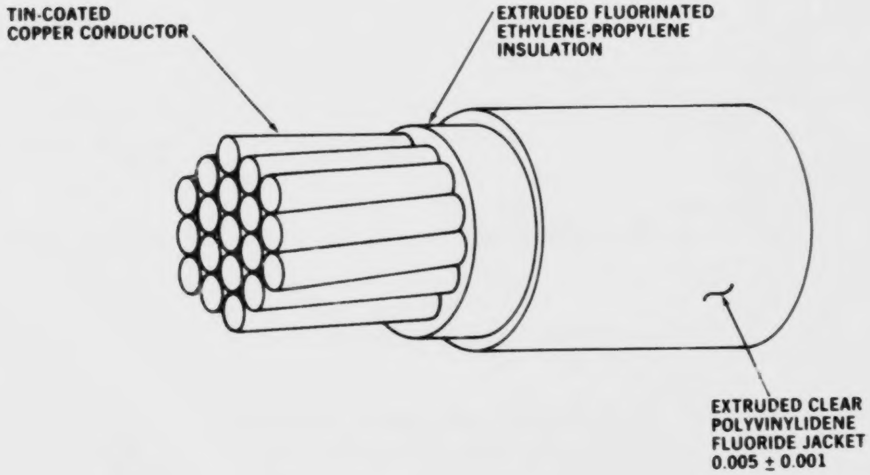

0.056
0.10
0.155
0.150
2.00

S 79666 (C17)

NOTES:
1. MAKE FROM MS21266-1N NYLON PLASTIC GROMMET STOCK, NSN 5325-00-960-2410.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-130.
4. TRIM PART TO SIZE ON INSTALLATION.

PART NUMBER: MS21266-1N NYLON PLASTIC EDGING.

FIGURE H-4. EDGING


TIN-COATED COPPER CONDUCTOR
EXTRUDED FLUORINATED ETHYLENE-PROPYLENE INSULATION
EXTRUDED CLEAR POLYVINYLIDENE FLUORIDE JACKET 0.005 ± 0.001

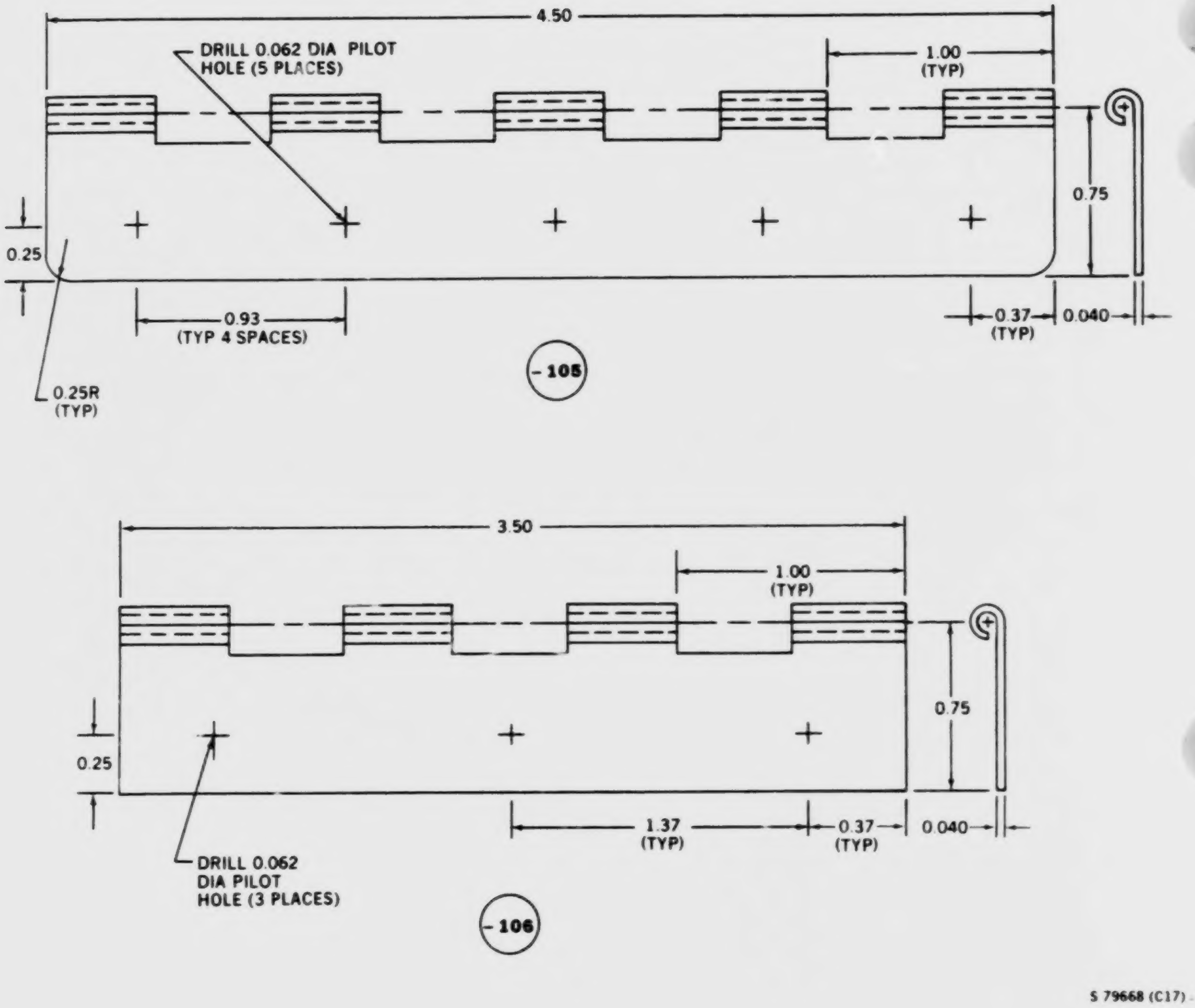
S 79667 (C17)

EXAMPLE: M22759/13-20-9-SIZE 20 WIRE, WHITE WITHOUT STRIPES OR BANDS.

NOTES:
1. MAKE FROM M22759/13-20-9 ELECTRICAL WIRE, NSN 6145-00-926-1211.
2. CUT WIRE TO REQUIRED LENGTH.
3. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER M22759/13-20-9 ELECTRICAL WIRE.

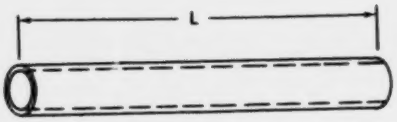
FIGURE H-5. ELECTRICAL WIRING


4.50
DRILL 0.062 DIA PILOT HOLE (5 PLACES)
1.00 (TYP)
0.75
0.25
0.93 (TYP 4 SPACES)
0.37 (TYP)
0.040
-105
0.25R (TYP)
3.50
1.00 (TYP)
0.75
0.25
1.37 (TYP)
0.37 (TYP)
0.040
DRILL 0.062 DIA PILOT HOLE (3 PLACES)
-106
S 79668 (C17)

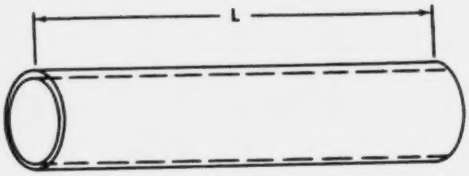
NOTES:
1. MAKE FROM MS35822-11A HINGE STOCK, NSN 5340-01-054-4936.
2. CUT HINGE TO SIZE AND FINISH ENDS AS SHOWN IN FIGURE.
3. DRILL PILOT HOLES, AS INDICATED, PER TM 55-1500-204-25/1.
4. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 70219-02315-105, -106 HINGE HALF.

FIGURE H-6. HINGE HALF



PM 21700



PM 21703

S 79669 (C17)

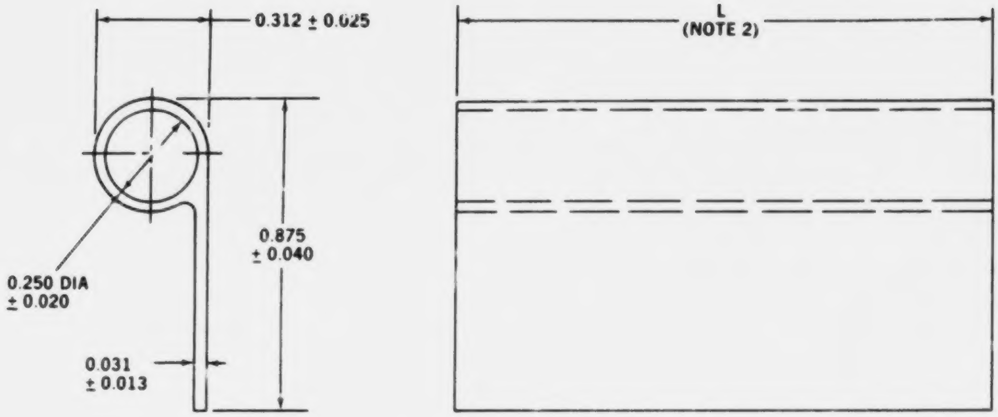
PART NUMBER AND DESCRIPTION	LENGTH (L) IN INCHES	MAKE FROM	NSN
PM21700 – CLEAR TUBING, 3/8 IN. ID MIL-I-7444, TY 1, CL 1	8.0	M23053/1-207-0	5970-01-085-2844
PM21703 – CLEAR TUBING, 3/4 IN. ID 3002 TRANSFLEX, MIL-I-631	40.5 ±0.5	M23053/8-011-C	5970-01-079-1999

NOTES:

1. MAKE TUBING PER CHART.
2. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: PM21700, PM21703 COLLECTIVE STICK GRIP ASSEMBLY TUBING.

FIGURE H-7. TUBING



S 79671 (C17)

SEAL PART NUMBER	LENGTH (L)	SIKORSKY PART NUMBER
SS2942-2	2.00	—
SS2942-3	3.00	—
SS2942-4.75	4.75	
SS2942-15	15.00	70302-02142-104
SS2942-15	15.00	70302-02142-108
*SS2942-35	35.00	70216-02401-107
*SS2942-38	38.00	70216-02402-124

*ALTERNATE PART.

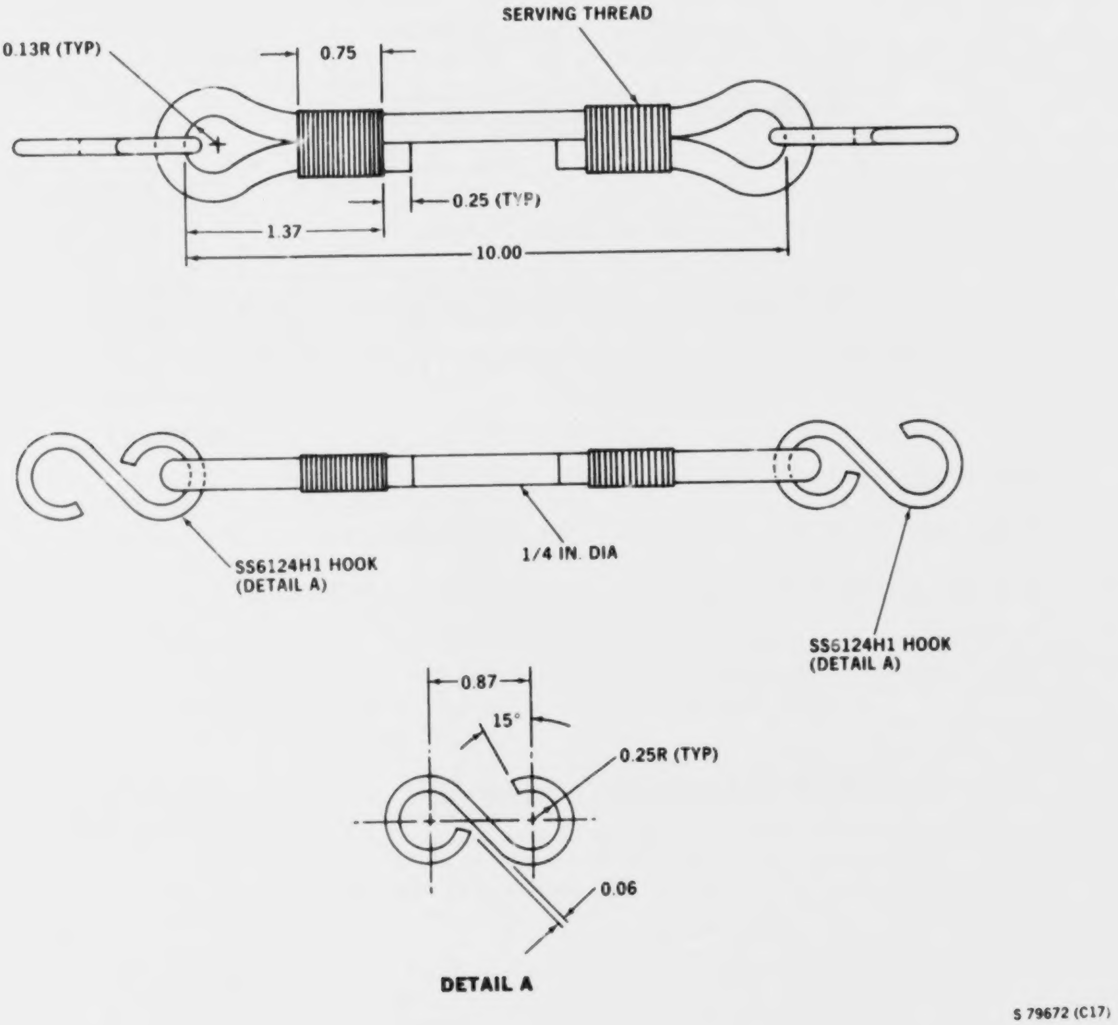
NOTES:

1. MAKE FROM SS2942 FORMED NEOPRENE, CLASS 2, GRADE 60, MIL-R-6855 SEAL STOCK, NSN 5330-01-136-1781.
2. DASH NUMBER IN SEAL PART NUMBER DESIGNATES LENGTH OF SEAL IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: SS2942-2, SS2942-3, SS2942-4.75, SS2942-15, SS2942-35, SS2942-38; 70216-02401-107, 70216-02402-124, 70302-02142-104, 70302-02142-108 SEAL

FIGURE H-8. SEAL

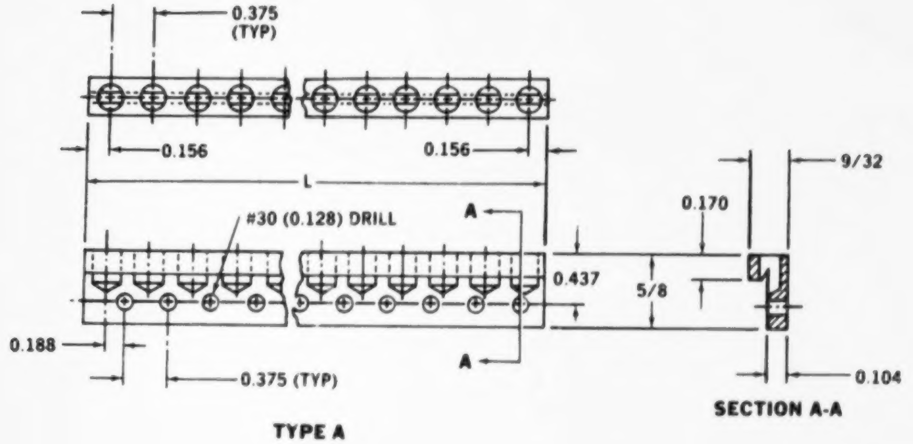

SERVING THREAD
0.13R (TYP)
0.75
0.25 (TYP)
1.37
10.00
SS6124H1 HOOK
(DETAIL A)
1/4 IN. DIA
SS6124H1 HOOK
(DETAIL A)
0.87
15°
0.25R (TYP)
0.06
DETAIL A
S 79672 (C17)

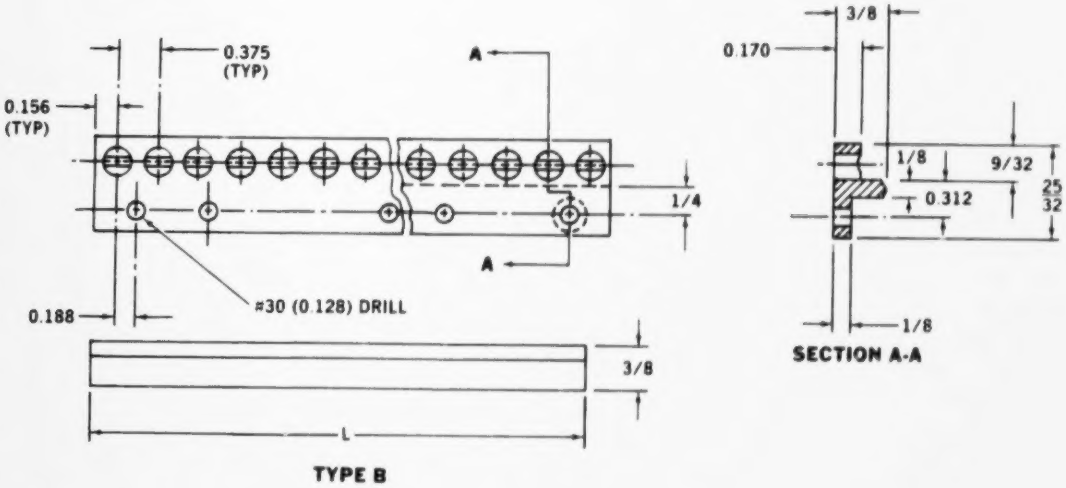
NOTES:

1. MAKE FROM:
    - A. CORD — 1/4-INCH-DIAMETER SHOCK ABSORBING, MIL-C-5651, NSN 8305-00-276-7575.
    - B. HOOK — 0.125-INCH-DIAMETER PASSIVATED CRES STEEL ROD, 302 COND. B, QQ-W-423, NSN 9505-00-684-0972.
    - C. THREAD — STYLE A, TYPE II, MIL-T-5660, NSN 8310-00-194-4065.
2. FABRICATE HOOKS AS SHOWN IN DETAIL A OF FIGURE.
3. CUT CORD TO REQUIRED LENGTH AND ASSEMBLE HOOKS. WRAP SERVING THREAD AS SHOWN, AND PER INSTRUCTIONS IN TM 55-1500-204-25/1.
4. COAT FINISHED SERVING THREAD WITH CLEAR SHELLAC, A-A-8, NSN 8010-00-160-6911.
5. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: SS6124-09-100 CORD ASSEMBLY.

FIGURE H-9. CORD ASSEMBLY


0.375
(TYP)
0.156
0.156
L
#30 (0.128) DRILL
A
A
0.437
5/8
0.170
9/32
0.104
0.188
0.375 (TYP)
SECTION A-A
TYPE A


0.375
(TYP)
0.156
(TYP)
A
A
1/4
#30 (0.128) DRILL
0.188
3/8
L
TYPE B
3/8
0.170
1/8
9/32
0.312
25/32
1/8
SECTION A-A

S 79673 (C17)

FIGURE H-10. PANEL FASTENER STRIP (SHEET 1 OF 2)

STRIP PART NUMBER	NUMBER OF HOLES	(L) LENGTH	MAKE FROM NSN
SS7001-7A	9	3.312	5325-00-036-9305
SS7001-61C	63	23.562	5325-00-036-9305
SS7001-15B	17	6.312	5325-00-036-9306
SS7001-21B	23	8.562	5325-00-036-9306
SS7001-24B	26	9.687	5325-00-036-9306

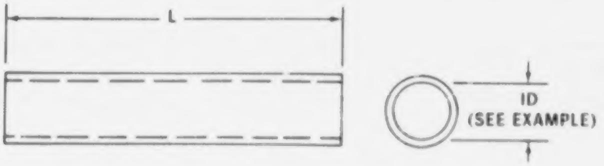
EXAMPLE: SS7001-7A — ANGLE TYPE STRIP 3.312 IN. LONG, WITH PROVISIONS FOR NINE FASTENERS.
EXAMPLE: SS7001-15B — FLAT TYPE STRIP 6.312 IN. LONG, WITH PROVISIONS FOR SEVENTEEN FASTENERS.

NOTES:

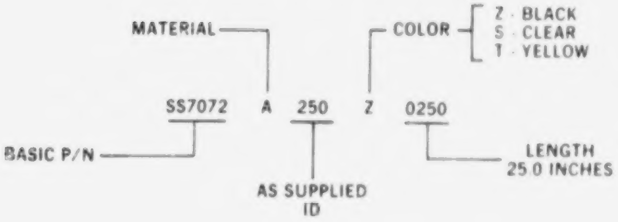
1. MAKE FROM STRIP PANEL STOCK, 6061-T6 ALUMINUM ALLOY, QQ-A-200/8 PER CHART.
2. DASH NUMBER DESIGNATES NUMBER OF FASTENER CONNECTION HOLES (CHART).
3. LETTER A IN DASH NUMBER DESIGNATES ANGLE TYPE STRIP. LETTER B IN DASH NUMBER DESIGNATES FLAT TYPE STRIP.
4. CUT STRIP TO REQUIRED LENGTH (CHART) AND FINISH ENDS AS SHOWN.
5. TREAT CUT EDGES AND DRILLED HOLES WITH CORROSION RESISTANT COMPOUND (ALODINE) MIL-C-5541, CLASS 3, NSN 8030-00-811-3723.
6. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: SS7001-7A, SS7001-61C, SS7001-15B, SS7001-21B, SS7001-24B, PANEL FASTENER STRIP.

FIGURE H-10. PANEL FASTENER STRIP (SHEET 2 OF 2)



EXAMPLE



S 79674 (C17)

SLEEVE PART NUMBER	LENGTH (L) IN INCHES	MAKE FROM	
		PART NUMBER	NSN
*SS7072A0187ZXXX	*	M23053/5-105-0	5970-00-954-1622
SS7072A0250Z180	18.0	M23053/5-106-0	5970-00-815-1295
SS7072A0250Z250	25.0	M23053/5-106-0	5970-00-815-1295
*SS7072A0375ZXXX	*	M23053/5-107-0	5970-00-954-1624
SS7072A0375Z050	5.0	M23053/5-107-0	5970-00-954-1624
SS7072A0500Z010	1.0	M23053/5-108-0	5970-00-812-2967
SS7072A0500Z150	15.0	M23053/5-108-0	5970-00-812-2967
SS7072A0500Z350	35.0	M23053/5-108-0	5970-00-812-2967
*SS7072A0750ZXXX	*	M23053/5-109-0	5970-00-914-3118
SS7072A0750Z014	1.4	M23053/5-109-0	5970-00-914-3118
SS7072A0750Z021	2.1	M23053/5-109-0	5970-00-914-3118
SS7072A0750Z022	2.2	M23053/5-109-0	5970-00-914-3118
SS7072A0750Z028	2.8	M23053/5-109-0	5970-00-914-3118
SS7072A0750Z029	2.9	M23053/5-109-0	5970-00-914-3118
SS7072A0750Z030	3.0	M23053/5-109-0	5970-00-914-3118
SS7072A0750Z045	4.5	M23053/5-109-0	5970-00-914-3118
SS7072A0750Z053	5.3	M23053/5-109-0	5970-00-914-3118
SS7072A0750Z055	5.5	M23053/5-109-0	5970-00-914-3118
SS7072A0750Z063	6.3	M23053/5-109-0	5970-00-914-3118
SS7072A0750Z073	7.3	M23053/5-109-0	5970-00-914-3118
SS7072A0750Z098	9.8	M23053/5-109-0	5970-00-914-3118
SS7072A0750Z860	86.0	M23053/5-109-0	5970-00-914-3118
SS7072A1000Z012	1.2	M23053/5-110-0	5970-00-815-1300
SS7072A1000Z023	2.3	M23053/5-110-0	5970-00-815-1300
SS7072B0125S015	1.5	M23053/8-004-C	5970-00-905-2068
SS7072B0187S015	1.5	+M23053/8-005-C	5970-00-761-1795

FIGURE H-11. INSULATION SLEEVE (SHEET 1 OF 2)

SLEEVE PART NUMBER	LENGTH (L) IN INCHES	MAKE FROM	
		PART NUMBER	NSN
SS7072B0250S015	1.5	M23053/8-006-C	5970-00-935-0082
SS7072E0250Z720	72.0	M23053/1-101-0	5970-00-063-1500
SS7072E0375Z600	60.0	M23053/1-102-0	5970-00-063-1499
SS7072E0375Z720	72.0	M23053/1-102-0	5970-00-063-1499
SS7072E0500T600	60.0	+ M23053/1-103-0	5970-00-063-1495
SS7072E0500Z008	0.8	M23053/1-103-0	5970-00-063-1495
SS7072E0500Z480	48.0	M23053/1-103-0	5970-00-063-1495
*SS7072E0625ZXXX	*	M23053/1-104-0	5970-01-044-4531
SS7072E0625Z260	26.0	M23053/1-104-0	5970-01-044-4531
SS7072E0625Z300	30.0	M23053/1-104-0	5970-01-044-4531
SS7072E0625Z360	36.0	M23053/1-104-0	5970-01-044-4531
SS7072E0750Z720	72.0	M23053/1-105-0	5970-00-063-1496
SS7072E1000T500	50.0	+ M23053/1-107-0	5970-01-044-4532
SS7072E1000T570	57.0	+ M23053/1-107-0	5970-01-044-4532
*SS7072E1000ZXXX	*	M23053/1-107-0	5970-01-044-4532
SS7072G02500020	2.0	M23053/1-101-0	5970-00-063-1500
SS7072L0125Z015	1.5	M23053/4-101-0	5970-01-057-0992

*LENGTH IS GREATER THAN 99.9 INCHES. DETERMINE LENGTH ON INSTALLATION.
+ ACCEPTABLE COLOR ALTERNATE.

NOTES:

1. MAKE SLEEVING PER CHART.
2. IDENTIFY PARTS PER MIL-STD-130.

FIGURE H-11. INSULATION SLEEVE (SHEET 2 OF 2)

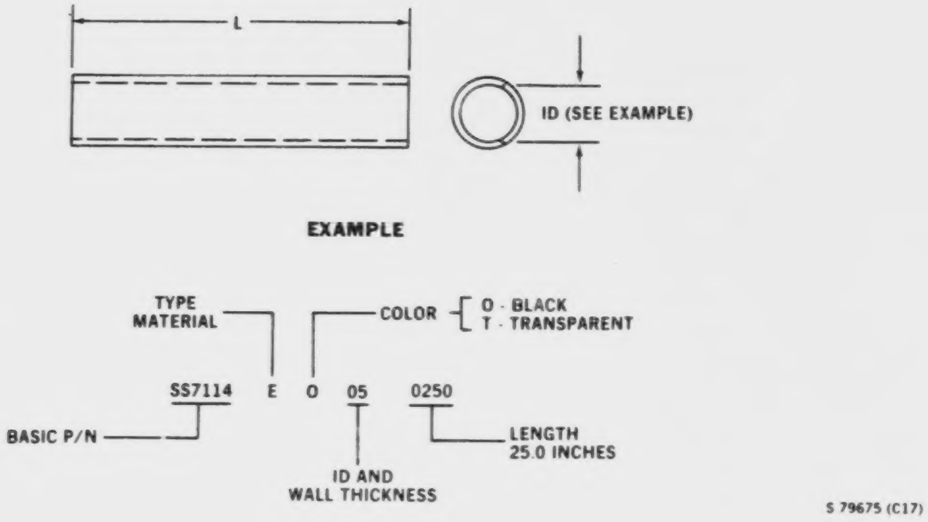

L
ID (SEE EXAMPLE)
EXAMPLE
TYPE MATERIAL
COLOR
O - BLACK
T - TRANSPARENT
SS7114 E O 05 0250
BASIC P/N
LENGTH 25.0 INCHES
ID AND WALL THICKNESS
S 79675 (C17)

CHART A

CODE	INSIDE DIA.		WALL THICK.		CODE	INSIDE DIA.		WALL THICK.	
	MIN	MAX	MIN	MAX		MIN	MAX	MIN	MAX
05	0.182	0.198	0.017	0.023	C	0.438	0.462	0.022	0.028
08	0.129	0.141	0.017	0.023	D	0.500	0.524	0.022	0.028
A	0.313	0.334	0.022	0.028	G	0.875	0.911	0.030	0.040
B	0.375	0.399	0.022	0.028					

FIGURE H-12. INSULATION TUBING (SHEET 1 OF 2)

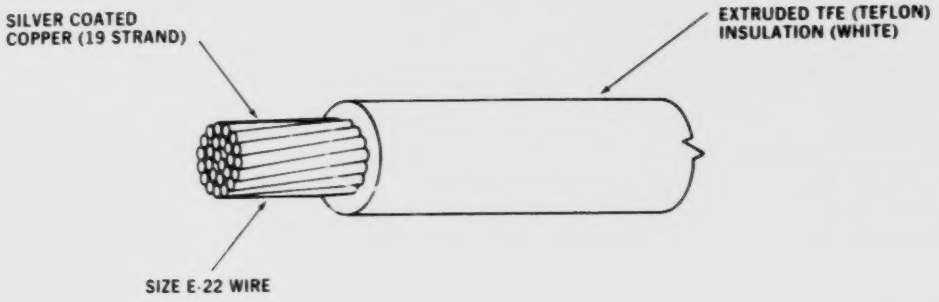
CHART B

SIKORSKY PART NUMBER	LENGTH (L)	MAKE FROM	NSN
SS7114E005-0250	25.0	TEMFLEX 105C (75037)	5970-00-845-4910
SS7114E005-0300	30.0	TEMFLEX 105C (75037)	5970-00-845-4910
SS7114ETA-0720	72.0	TEMFLEX 105C 6 AW O CLEAR (75037)	5970-00-189-5850
SS7114ETB-0600	60.0	TEMFLEX 105C 3/8 INCH CLEAR (75037)	5970-00-889-3844
SS7114ETC-0480	48.0	TEMFLEX 105C 7/16 INCH CLEAR (75037)	5970-00-990-9142
SS7114ETC-0840	84.0	TEMFLEX 105C 7/16 INCH CLEAR (75037)	5970-00-990-9142
SS7114ETD-0565	56.5	TEMFLEX 105C 1/2 INCH CLEAR (75037)	5970-00-685-9057
SS7114ETG-0840	84.0	TEMFLEX 105C 7/8 INCH CLEAR (75037)	5970-00-958-6760
SS7114ET05-0840	84.0	TEMFLEX 105C 5 AW 6 CLEAR (75037)	5970-00-078-5977
SS7114ET08-1610	161.0	8034668-145 (18876)	5970-00-553-7120

NOTES:

1. MAKE TUBING PER CHART B.
2. IDENTIFY PARTS PER MIL-STD-130.

FIGURE H-12. INSULATION TUBING (SHEET 2 OF 2)


SILVER COATED COPPER (19 STRAND)
EXTRUDED TFE (TEFLON) INSULATION (WHITE)
SIZE E-22 WIRE

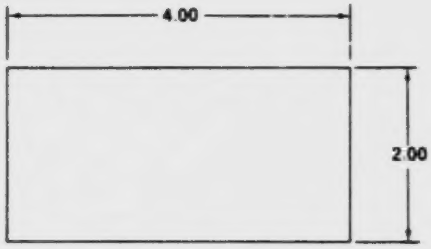
S 79676 (C17)

SIKORSKY PART NUMBER	SIZE	MAKE FROM PART NUMBER	MAKE FROM NSN
SS7311-22-9	E-22	M22759/11-229	6145-01-080-8298
SS7311-16-9	E-16	M22759/11-16-9 M16878/4 BJE9	6145-01-108-6907

NOTES:
1. MAKE FROM TYPE E, SIZE (SEE CHART), SILVER COATED COPPER WIRE WITH WHITE INSULATION.
2. CUT WIRE TO REQUIRED LENGTH.
3. IDENTIFY PARTS PER MIL-STD-681.

PART NUMBER: SS7311-16-9, SS7311-22-9 ELECTRICAL WIRE.

FIGURE H-13. HIGH TEMPERATURE ELECTRICAL WIRE

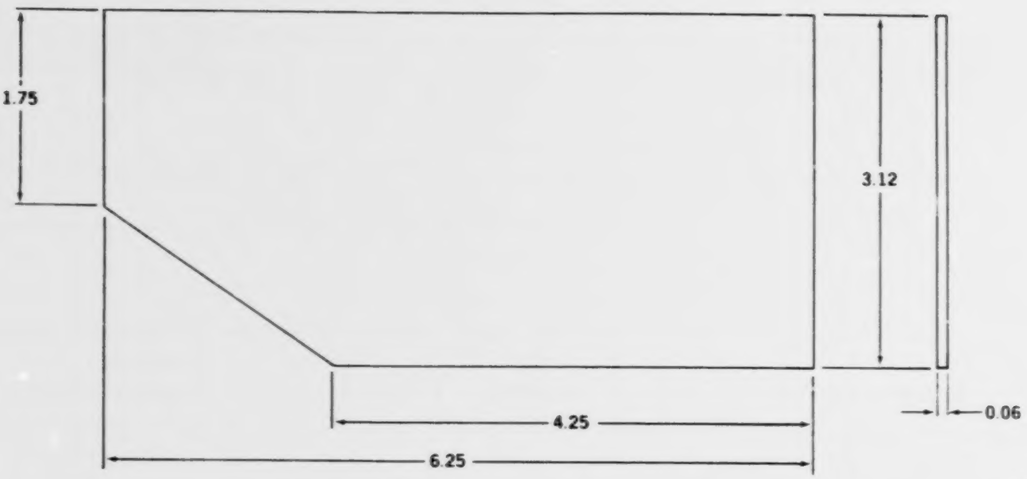


S 79677 (C17)

NOTES:
1. MAKE FROM 0.032 INCH THICK RUBBER SHEET, CLASS I, GRADE 60, MIL-R-5847, NSN 1560-01-096-5342.
2. IDENTIFY PARTS PER MIL-STD-190.

PART NUMBER: S6120-61188-016 SEAL RETAINER STRIP.

FIGURE H-14. SEAL RETAINER STRIP



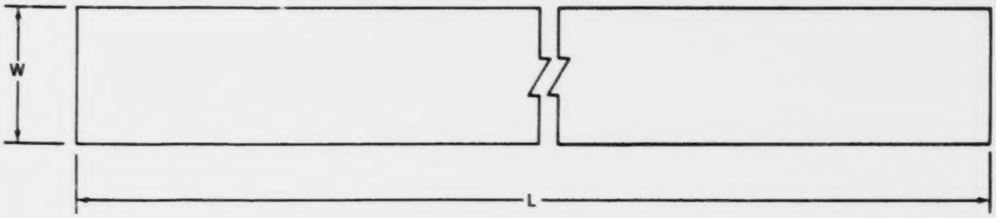
S 79777 (C17)

NOTES:

1. MAKE FROM MIL-C-3133, GRADE SBE 11L, 0.063-INCH THICK RUBBER SHEET, NSN 9320-00-580-6756.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 70500-03050-165 REAR BULKHEAD SEAL.

FIGURE H-15. AFT BULKHEAD SEAL



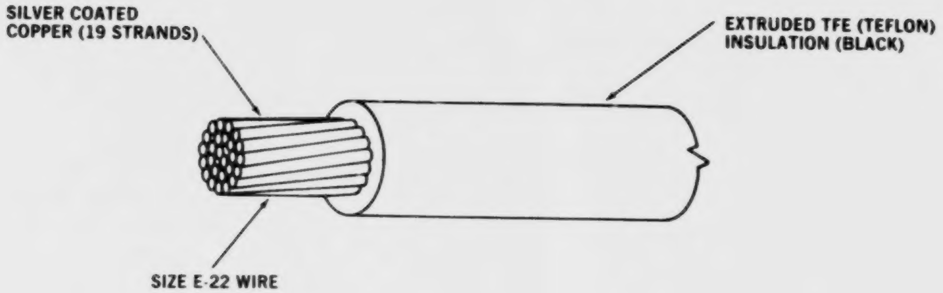
S 79770 (C17)

NOMENCLATURE	W WIDTH	L LENGTH	SIKORSKY PART NUMBER
FLAP CEILING CENTER PANEL	1.19	3.90	70500-02061-121
		13.56	70500-02061-122
		6.36	70500-02061-123
FLAP, CEILING PANEL	1.50	15.59	70500-02062-124

NOTES:
1. MAKE FROM VINYL COATED NYLON; COLOR, AN 620 LIGHT GULL GRAY SPECIFICATION MIL-C-20696, TYPE I, CLASS 2, NSN 8305-00-205-1163.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 70500-02061-121, -122 -123, -124 CEILING CENTER PANEL FLAP.

FIGURE H-16. CEILING CENTER PANEL FLAP


SILVER COATED COPPER (19 STRANDS)
EXTRUDED TFE (TEFLON) INSULATION (BLACK)
SIZE E-22 WIRE

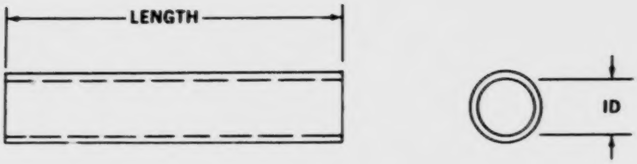
S 79680 (C17)

WIRE PART NUMBER	LENGTH IN INCHES	MAKE FROM	
		PART NUMBER	NSN
S8935FOS200	20.0	M16878/4 BFE0	6145-01-017-9693
S8935FOS60	6.0	M16878/4 BFE0	6145-01-017-9693

NOTES:
1. MAKE FROM TYPE E, SIZE E-22, SILVER COATED COPPER WIRE WITH BLACK TFE INSULATION, PER TABLE.
2. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: S8935FOS60, S8935FOS200 ELECTRICAL WIRE.

FIGURE H-17. HIGH TEMPERATURE ELECTRICAL WIRE



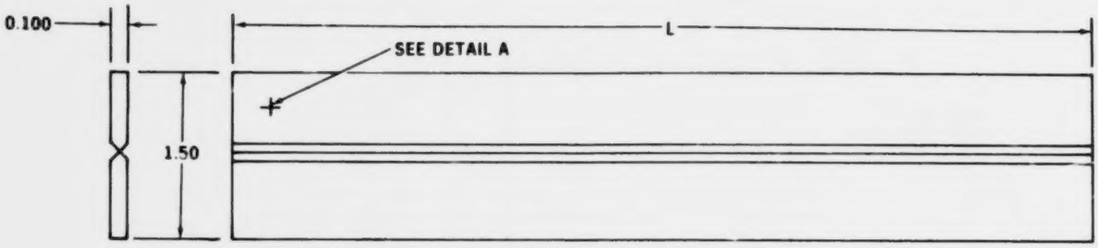
S 79681 (C17)

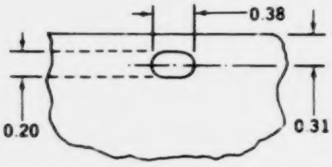
SLEEVE PART NUMBER	AS SUPPLIED ID	LENGTH IN INCHES	MAKE FROM	
			PART NUMBER	NSN
S9352-8-9-100	0.250	1.00	M23053/6-106-9	5970-01-147-3596
S9352-10-9-600	0.187	6.00	M23053/6-105-9	5970-00-067-9373
S9352-10-9-2000	0.187	20.00	M23053/6-105-9	5970-00-067-9373

NOTES:
1. MAKE SLEEVE FROM WHITE, HEAT SHRINKABLE, POLYOLEFIN TUBING PER CHART.
2. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: S9352-8-9-100, S9352-10-9-600, S9352-10-9-2000 INSULATION SLEEVE.

FIGURE H-18. INSULATION





DETAIL A
SLOTS (8 PLACES)
FOR 70500-62062-107 ONLY

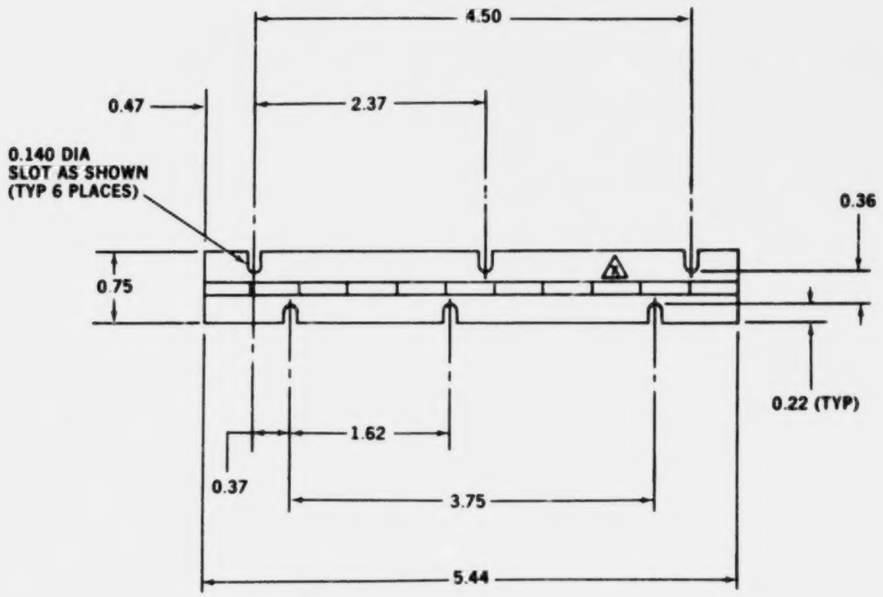
S 79682 (C17)

PART NUMBER	LENGTH (L)
70500-02060-120	26.562
70500-02060-121	7.812
70500-02062-107	47.187
70500-02062-137	12.500
70500-02062-146	47.187
70500-02063-149	41.500
70500-02063-179	4.687
70500-02063-184	5.000
70500-02064-136	60.000

NOTES:
1. MAKE FROM GRAY THERMOPLASTIC POLYHINGE, NSN 9390-01-171-5986 PER CHART.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-130.
4. PICK UP FASTENER HOLE LOCATION ON INSTALLATION AND DRILL PER TM 55-1500-204-25/1.

PART NUMBER: 70500-02060-120, 70500-02060-121, 70500-02062-107, 70500-02062-137, 70500-02062-146, 70500-02063-149, 70500-02063-179, 70500-02063-184, 70500-02064-136 POLYHINGE.

FIGURE H-19. POLYHINGE

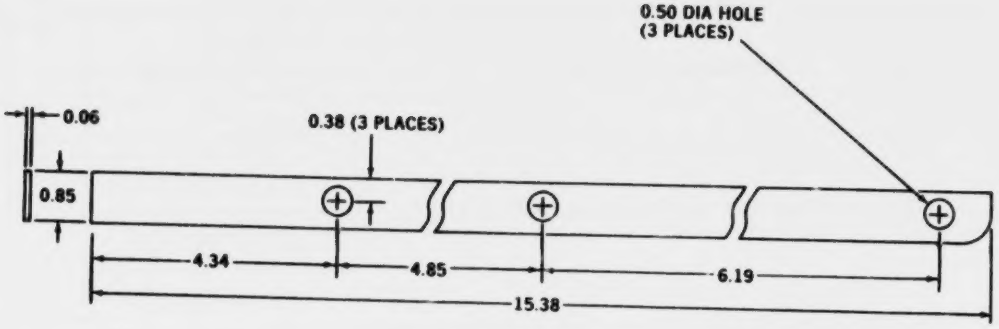

4.50
0.47
2.37
0.140 DIA
SLOT AS SHOWN
(TYP 6 PLACES)
0.36
0.75
0.22 (TYP)
1.62
0.37
3.75
5.44

S 79683 (C17)

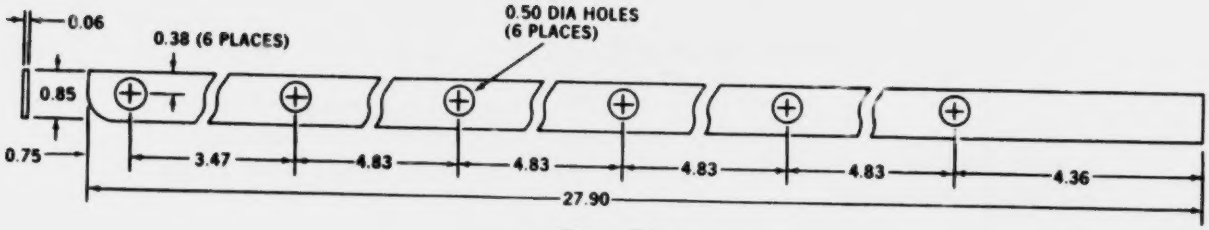
NOTES:
1. MAKE FROM MS20257-1 UNANODIZED HINGE STOCK, NSN 5340-00-057-2625.
2. ALL DIMENSIONS ARE IN INCHES.
3. REMOVE ALL BURRS AND SHARP EDGES.
4. TREAT CUT EDGES WITH CORROSION RESISTANT COMPOUND (ALODINE) MIL-C-5541, NSN 8030-00-811-3723.
5. IDENTIFY PARTS PER MIL-STD-130 IN LOCATION SHOWN BY △X IN F/D.

PART NUMBER: 70700-20680-108 TEST BOX ASSEMBLY HINGE.

FIGURE H-20. TEST BOX ASSEMBLY HINGE


0.50 DIA HOLE
(3 PLACES)
0.06
0.38 (3 PLACES)
0.85
4.34
4.85
6.19
15.38

(-132) (-138)


0.06
0.38 (6 PLACES)
0.50 DIA HOLES
(6 PLACES)
0.85
0.75
3.47
4.83
4.83
4.83
4.83
4.36
27.90

(-135) (-139)

S 79684.1 (C17)

FIGURE H-21. FUEL LINES AND PUMP ENCLOSURE SEAL (SHEET 1 OF 6)

NOMENCLATURE	SIKORSKY PART NUMBER
FUEL LINES AND PUMP ENCLOSURE SEALS	70219-03002-132
	70219-03002-138
	70219-03002-135
	70219-03002-139

NOTES:

1. MAKE FROM SHEET RUBBER, MIL-STD-670, SCE 7L, 0.062 INCH THICK, NSN 9320-00-929-5316.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70219-03002-132, -135, -138, -139 FUEL LINES AND PUMP ENCLOSURE SEALS.

FIGURE H-21. FUEL LINES AND PUMP ENCLOSURE SEAL (SHEET 2 OF 6)

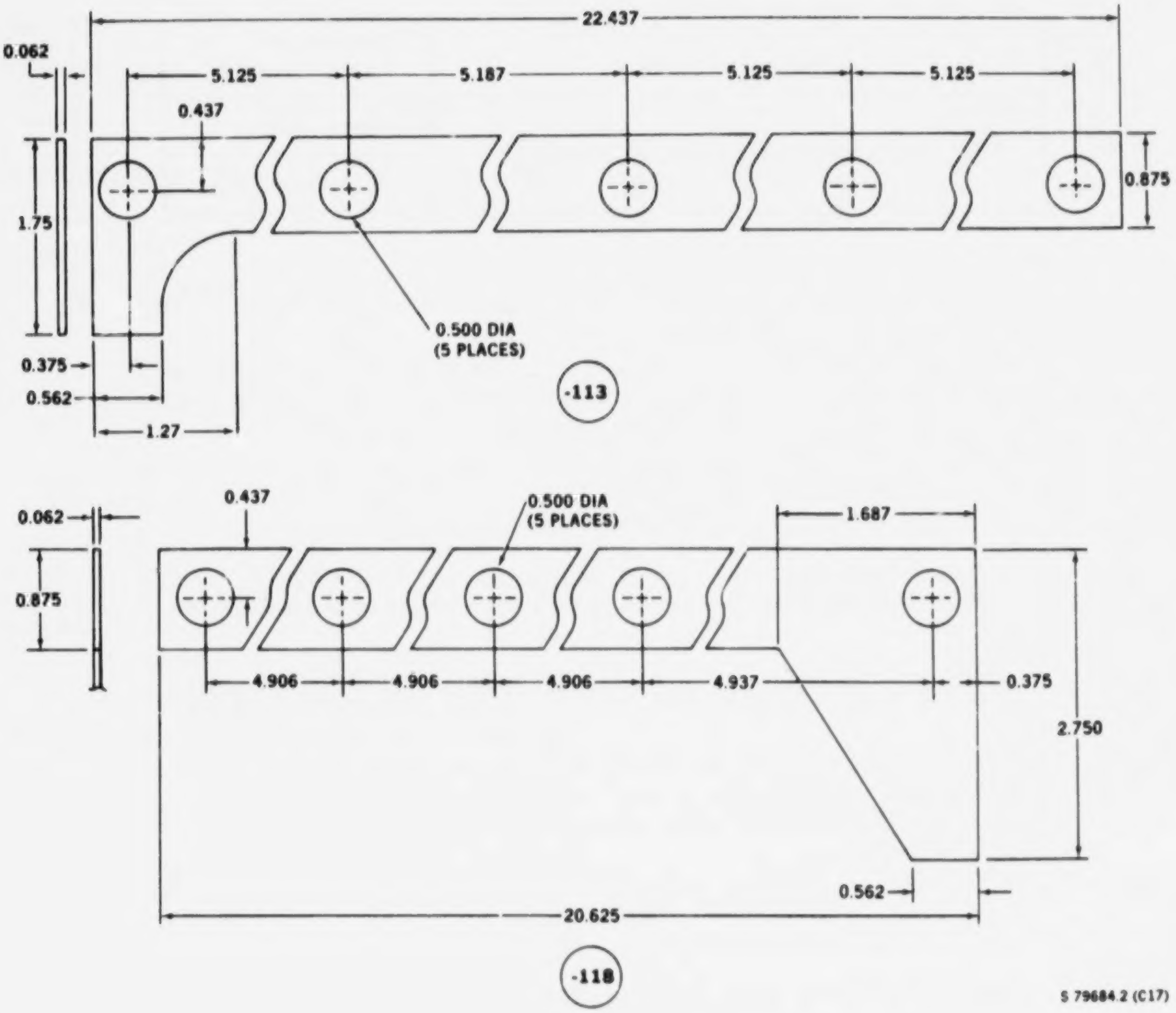

22.437
0.062
5.125
5.187
5.125
5.125
0.437
1.75
0.875
0.500 DIA
(5 PLACES)
0.375
0.562
1.27
-113
0.062
0.437
0.500 DIA
(5 PLACES)
1.687
0.875
4.906
4.906
4.906
4.937
0.375
2.750
0.562
20.625
-118
S 79684.2 (C17)

FIGURE H-21. FUEL LINES AND PUMP ENCLOSURE SEAL (SHEET 3 OF 6)

NOMENCLATURE	SIKORSKY PART NUMBER
FUEL LINES AND PUMP ENCLOSURE SEALS	70219-03002-113
	70219-03002-118

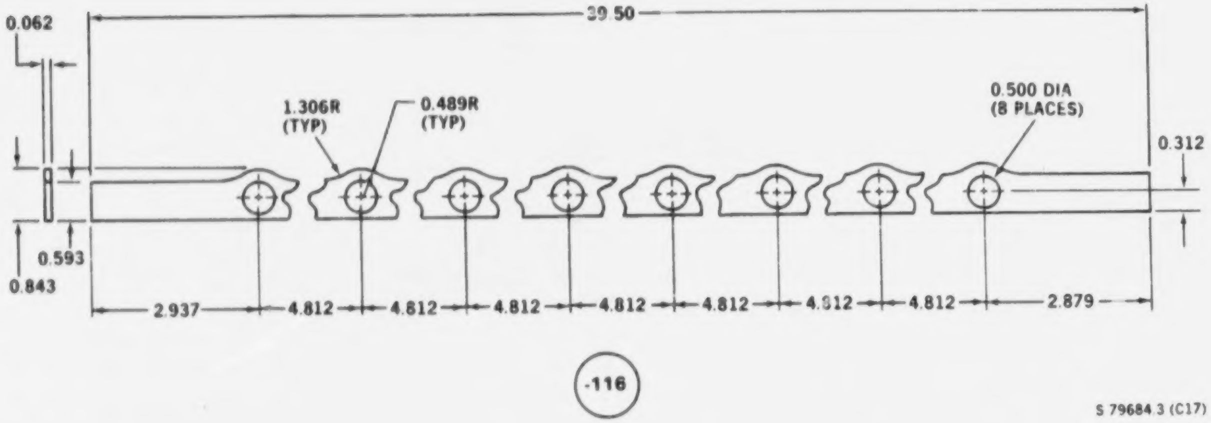
NOTES:

1. MAKE FROM SHEET RUBBER, MIL-STD-670, SCE 7L, 0.062 INCH THICK, NSN 9320-00-929-5316.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: $\underbrace{\text{P/N 70216-02401-107}}_{\text{PART NUMBER}}$ $\underbrace{\text{3Q}}_{\text{THIRD QUARTER}}\ \underbrace{\text{86}}_{\text{1986}}$

PART NUMBER: 70219-03002-113, -118 FUEL LINES AND PUMP ENCLOSURE SEALS.

FIGURE H-21. FUEL LINES AND PUMP ENCLOSURE SEAL (SHEET 4 OF 6)


0.062
39.50
1.306R
(TYP)
0.489R
(TYP)
0.500 DIA
(8 PLACES)
0.312
0.593
0.843
2.937
4.812
4.812
4.812
4.812
4.812
4.812
4.812
2.879
-116

S 79684.3 (C17)

NOMENCLATURE	SIKORSKY PART NUMBER
FUEL LINES AND PUMP ENCLOSURE SEAL	70219-03002-116

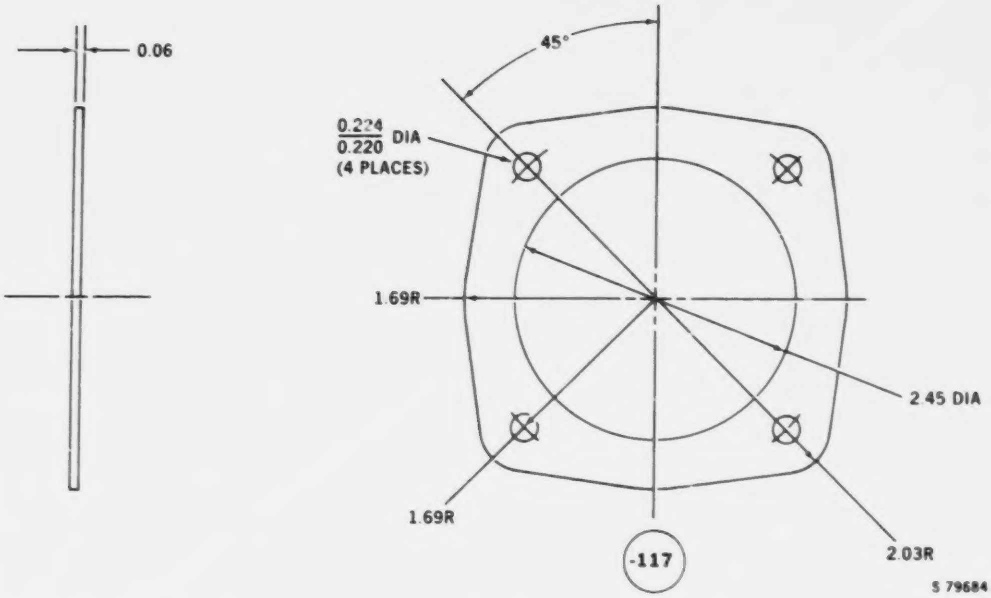
NOTES:

1. MAKE FROM SHEET RUBBER, MIL-STD-670, SCE 7L, 0.062 INCH THICK, NSN 9320-00-929-5316.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70219-03002-116 FUEL LINES AND PUMP ENCLOSURE SEALS.

FIGURE H-21. FUEL LINES AND PUMP ENCLOSURE SEAL (SHEET 5 OF 6)



S 79684 4 (C17)

NOMENCLATURE	SIKORSKY PART NUMBER
FUEL LINES AND PUMP ENCLOSURE SEAL	70219-03002-117

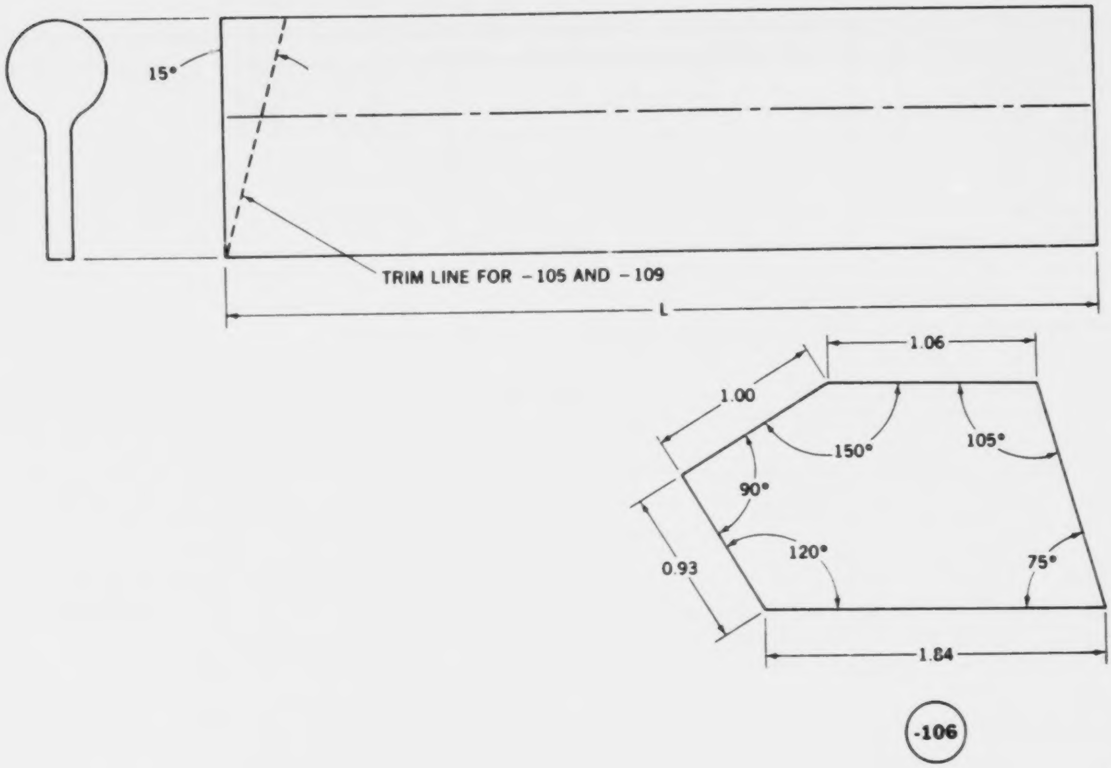
NOTES:

1. MAKE FROM SHEET RUBBER, MIL-STD-670, SCE 7L, 0.062 INCH THICK, NSN 9320-00-929-5316.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70219-03002-117 FUEL LINES AND PUMP ENCLOSURE SEAL.

FIGURE H-21. FUEL LINES AND PUMP ENCLOSURE SEAL (SHEET 6 OF 6)


15°
TRIM LINE FOR − 105 AND − 109
L
1.06
1.00
150°
105°
90°
0.93
120°
75°
1.84
-106

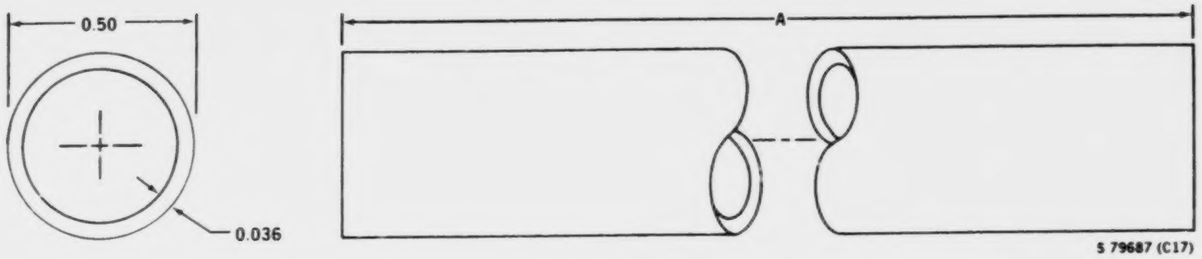
S 79685 (C17)

NOMENCLATURE	LENGTH "L"	SIKORSKY PART NUMBER
SEAL, APU FIREWALL	17.53	70303-03023-105
SEAL, APU FIREWALL	AS SHOWN	70303-03023-106
SEAL, APU FIREWALL	18.12	70303-03023-109
SEAL, APU FIREWALL	12.50	70303-03023-113

NOTES:
1. MAKE FROM SEAL TAPE, STYLE JM150-13A, NSN 5330-00-849-7083.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-130.
4. TRIM SEALS AS REQUIRED TO BUTT JOIN WITH NO GAP.

PART NUMBER: 70303-03023-105, -106, -109, -113 AUXILIARY POWER UNIT FIREWALL SEAL.

FIGURE H-22. AUXILIARY POWER UNIT FIREWALL SEAL


0.50
0.036
A
S 79687 (C17)

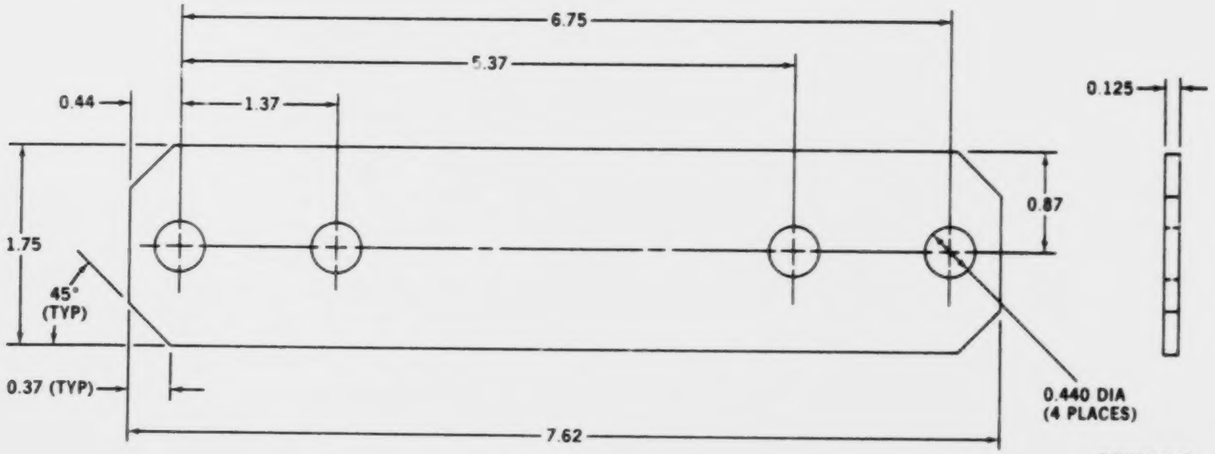
NOMENCLATURE	DIMENSION "A"	SIKORSKY PART NUMBER
TAIL ROTOR CABLE CONDUIT	95.00	70400-00510-101
	35.00	70400-00510-102

NOTES:

1. MAKE FROM NYLON TUBING, L-P-410A TYPE LF, NSN 4720-01-008-9453.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PART PER MIL-STD-130.

PART NUMBER: 70400-00510-101, -102 TAIL ROTOR CABLE CONDUIT.

FIGURE H-23. AUXILIARY POWER UNIT FIREWALL SEAL

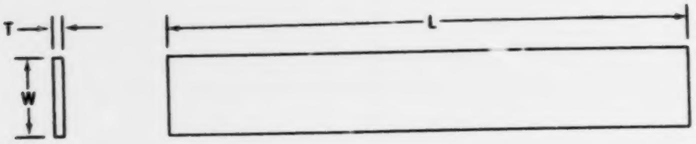

6.75
5.37
0.44
1.37
0.125
0.87
1.75
45° (TYP)
0.37 (TYP)
0.440 DIA (4 PLACES)
7.62
S 79819 (C17)

NOTES:

1. MAKE FROM 0.125 INCH THICK NYLON 6/6 L-P-410, NSN 9330-01-028-9334.
2. ALL DIMENSIONS ARE IN INCHES.
3. PICK UP HOLES ON INSTALLATION.
4. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER 70700-20509-104 PLATE.

FIGURE H-24. PLATE



S 79689 (C17)

NOMENCLATURE	T THICKNESS	W WIDTH	L LENGTH	SIKORSKY PART NUMBER
BATTERY BOX SEALS	0.062	0.32	21.50	70209-02532-102
			8.67	70209-02532-103
				70209-02532-104
ACCUMULATOR BRACKET CUSHIONS		0.75	8.50	70209-03018-110
				70209-03018-111
				70209-03018-121
				70209-03018-122
CARGO HOOK ACCESS SEALS		0.67	62.0	70214-02556-111
			19.20	70214-02556-112
		0.41		70214-02556-116

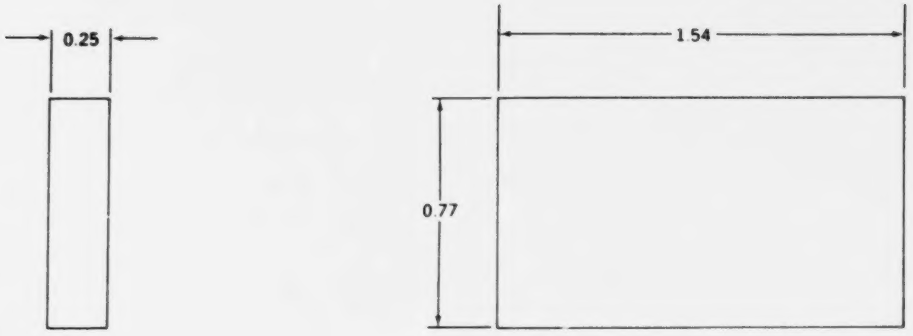
NOTES:

1. MAKE FROM MIL-R-6855, CLASS 2, TYPE B, GRADE 60 RUBBER 0.062 INCH THICK, NSN 9320-01-157-9070.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70209-02532-102, -103, -104, 70209-03018-110, -111, -121, -122, 70214-02556-111, -112, -116 BATTERY BOX, CARGO HOOK ACCESS SEALS, AND ACCUMULATOR BRACKET CUSHIONS.

FIGURE H-25. BATTERY BOX, CARGO HOOK ACCESS SEAL AND ACCUMULATOR BRACKET CUSHION



S 79690 (C17)

NOMENCLATURE	SIKORSKY PART NUMBER
FORMER INSTALLATION GASKET	70212-02139-108

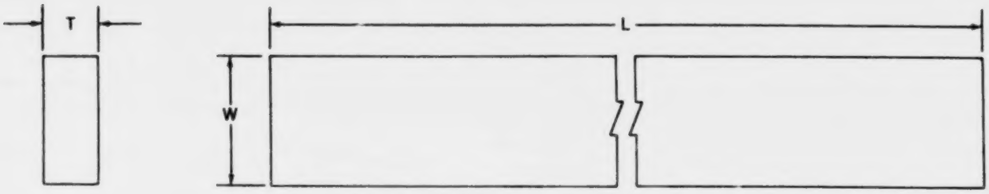
NOTES:

1. MAKE FROM RUBBER, MIL-R-6855, CLASS II, GRADE 60, NSN 9320-01-241-9763.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70212-02139-108 FORMER INSTALLATION GASKET.

FIGURE H-26. FORMER INSTALLATION GASKET



S 79691 (C17)

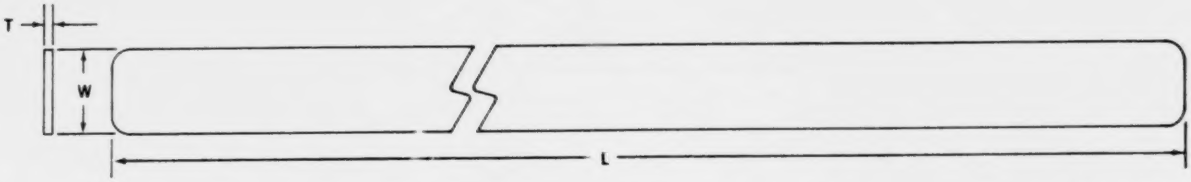
NOMENCLATURE	T THICKNESS	W WIDTH	L LENGTH	SIKORSKY PART NUMBER
SUPPORT INSTALLATION SEAL	0.375	0.75	6.86	70212-02137-145

NOTES:
1. MAKE RUBBER, MIL-R-6130, TYPE 2, GRADE A, NSN 9320-00-108-6500.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70212-02137-145 SUPPORT INSTALLATION SEAL.

FIGURE H-27. SUPPORT INSTALLATION SEAL



S 79692.1 (C17)

NOMENCLATURE	T THICKNESS	W WIDTH	L LENGTH	SIKORSKY PART NUMBER
PYLON DOOR CHAFING STRIP	0.062	0.84	14.53	70219-04500-102
		0.50	13.69	70219-04500-103
		0.75	22.50	70219-04500-104
		0.50	21.00	70219-04704-106
		0.71	37.00	70219-04704-107
		0.50	18.75	70219-04704-108
		0.50	16.87	70219-04704-111

NOTES:

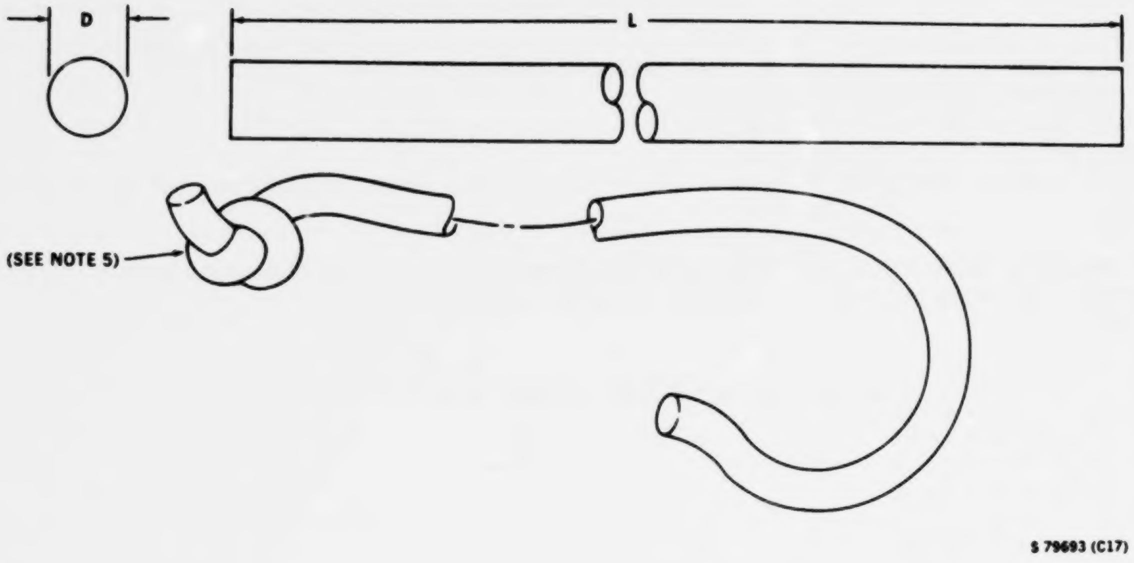
1. MAKE FROM RUBBER, MIL-C-3133, MIL-STD-670, GRADE SCE 3L, 0.062 INCH THICK, NSN 9320-01-269-2863. ALTERNATE, RUBBER, MIL-C-3133, MIL-STD-670, GRADE SBE 11L 0.062-INCH THICK, NSN 9320-00-580-6756.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PART PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER
1986
THIRD QUARTER

4. TRIM TO FIT AS REQUIRED.

PART NUMBER: 70219-04500-102, -103, -104, 70219-04704-106, -107, -108, -111, PYLON DOOR CHAFING STRIP.

FIGURE H-28. PYLON DOOR CHAFING STRIP



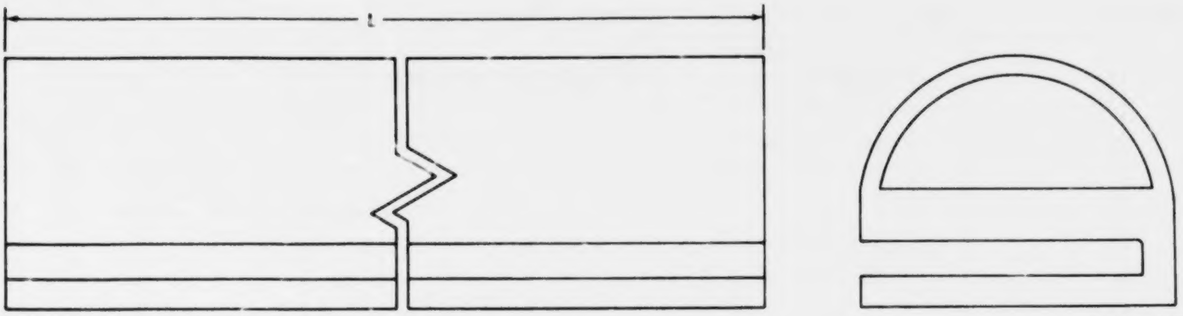
NOMENCLATURE	L LENGTH	D DIAMETER	SIKORSKY PART NUMBER
PLUG HANDLE ROPE	264.0	0.375	70700-20369-102
	108.0		70700-20507-104
	46.0		70700-20508-102
	31.0		70700-20509-103
	48.0		70700-20512-103
	36.0		70700-20512-106
	24.0		70700-20514-103
	48.0		70700-20515-102
	53.0		70700-20515-104

FIGURE H-29. ROPE PLUG HANDLE (SHEET 1 OF 2)

NOTES:
1. MAKE FROM NYLON ROPE, MIL-R-17343, NSN 4020-00-641-8899.
2. ALL DIMENSIONS ARE IN INCHES.
3. SINGE ENDS TO PREVENT UNRAVELING.
4. IDENTIFY PARTS PER MIL-STD-130.
5. INSTALL ROPE THROUGH 70700-20507-105 WASHER AND INLET PLUG. TIE AND HEAT-SEAL KNOT.

PART NUMBER: 70700-20369-102, 70700-20507-104, 70700-20508-102, 70700-20509-103, 70700-20512-103, 70700-20512-106, 70700-20514-103, 70700-20515-104 PLUG HANDLE ROPE.

FIGURE H-29. ROPE PLUG HANDLE (SHEET 2 OF 2)



S 79694 (C17)

NOMENCLATURE	L LENGTH	SIKORSKY PART NUMBER
CREW DOOR SEAL	1890.0	S6122-82279-003
GUNNER'S WINDOW SEAL	36.75	70216-02401-104
	36.75	70216-02402-110
	38.34	70216-02402-124
CARGO DOOR, WINDOW SEAL	106.00	70217-02701-101
	106.00	70217-02701-107
MAIN ROTOR PYLON SEAL	36.00	70219-04200-135

NOTES:

1. MAKE FROM AMS 3240 RUBBER EXTRUSION, PART NUMBER S6122-82279-001, NSN 5330-00-938-7097.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: S6122-82279-003, 70216-02401-104, 70216-02402-110, 70216-02402-124, 70217-02701-101, 70217-02701-107, 70219-04200-135 CREW DOOR, GUNNER'S WINDOW, CARGO DOOR, AND ROTOR PYLON SEALS.

FIGURE H-30. CREW DOOR AND GUNNERS WINDOW, CARGO DOOR AND ROTOR PYLON SEAL

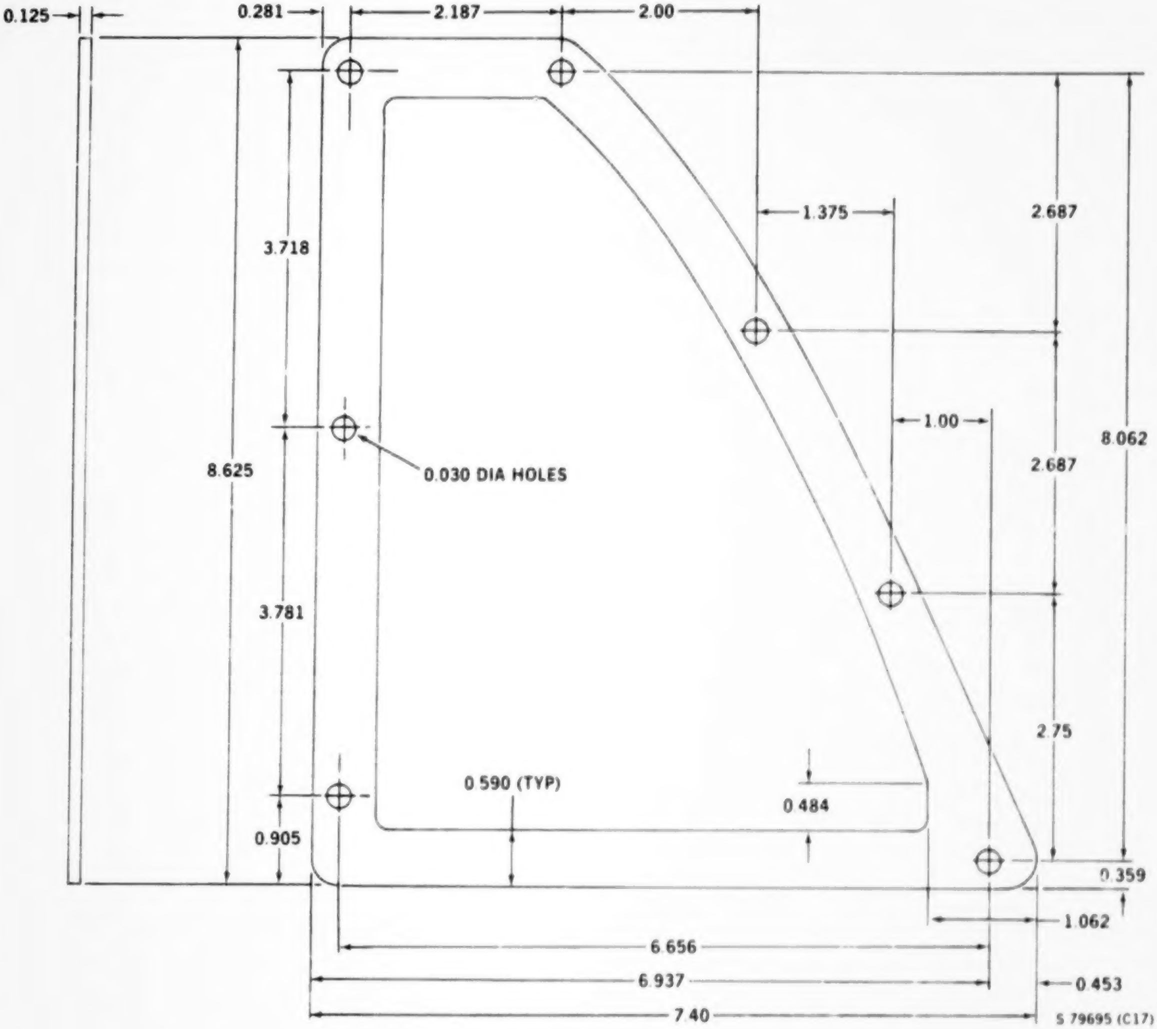

0.125
0.281
2.187
2.00
1.375
2.687
3.718
1.00
8.062
8.625
0.030 DIA HOLES
2.687
3.781
2.75
0.590 (TYP)
0.484
0.905
0.359
1.062
6.656
6.937
0.453
7.40
S 79695 (C17)

FIGURE H-31. CABIN DUCT SEAL (SHEET 1 OF 2)

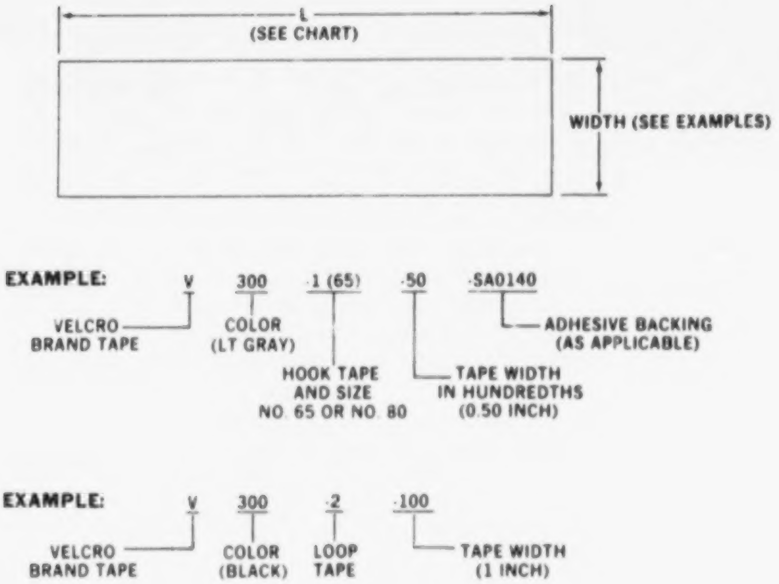
NOMENCLATURE	SIKORSKY PART NUMBER
CABIN DUCT SEAL	70500-02057-102

NOTES:
1. MAKE FROM RUBBER, MIL-R-6855, TYPE A, CLASS 2, GRADE 40, 0.125 THICK, NSN 9320-00-241-9759.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PART PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GRAY INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70500-02057-102, CABIN DUCT SEAL.

FIGURE H-31. CABIN DUCT SEAL (SHEET 2 OF 2)


L
(SEE CHART)
WIDTH (SEE EXAMPLES)
EXAMPLE:
V
300
-1 (65)
-50
-SA0140
VELCRO BRAND TAPE
COLOR (LT GRAY)
HOOK TAPE AND SIZE NO. 65 OR NO. 80
TAPE WIDTH IN HUNDREDTHS (0.50 INCH)
ADHESIVE BACKING (AS APPLICABLE)
EXAMPLE:
V
300
-2
-100
VELCRO BRAND TAPE
COLOR (BLACK)
LOOP TAPE
TAPE WIDTH (1 INCH)

S 79696 (C17)

VELCRO TAPE PART NUMBER	LENGTH (L)	SIKORSKY PART NUMBER	NSN
V300-1(65)-50 (NOTE 3)	–	–	8315-00-168-3280
V300-1(65)-63	43.68	70500-02053-119	8315-00-935-6762
	34.50	70500-02053-120	
	12.75	70500-02053-121	
	3.12	70500-02061-127	
	10.87	70500-02061-128	
	6.37	70500-02061-129	
	16.00	70500-02062-125	
V300-1(65)-75	–	–	8315-00-901-9717
V300-1(65)-100	–	–	8315-00-168-3280
V300-1(65)-150 (NOTE 4)	0.81	70500-02063-124	8315-00-901-9717
	1.75	70500-02063-126	
	0.75	70500-02063-152	
	3.50	70500-02063-212	
	4.00	70500-02063-214	
	4.12	70500-02063-216	
V300-1(65)-150	2.25	70500-02063-218	8315-00-901-9717
	5.00	70500-02063-220	
	2.00	70500-02063-222	
	2.00	70500-02064-135	

FIGURE H-32. VELCRO TAPE (SHEET 1 OF 4)

VELCRO TAPE PART NUMBER	LENGTH (L)	SIKORSKY PART NUMBER	NSN
	0.75	70500-02064-143	
	5.00	70500-02064-212	
	5.00	70500-02064-214	
	5.50	70500-02064-216	
	9.62	70500-02064-221	
V300-2-63	57.31	70500-02053-122	8315-00-935-6723
	48.12	70500-02053-123	
	10.87	70500-02061-125	
	6.37	70500-02061-126	
	16.00	70500-02062-126	
V300-2-75		–	8315-01-133-9781
V300-2-150 (NOTE 5)	0.81	70500-02063-125	8315-01-133-9781
	3.50	70500-02063-211	
	4.00	70500-02063-213	
	4.12	70500-02063-215	
	2.25	70500-02063-217	
	5.00	70500-02063-219	
	2.00	70500-02063-221	
	0.75	70500-02064-142	
	4.00	70500-02064-210	
	2.50	70500-02064-211	
	5.00	70500-02064-213	
	5.00	70500-02064-215	
	5.50	70500-02064-217	
V300-1(65)-50-SA0140 (NOTE 7)	95.00	70070-20014-102	NOTE 6
	70.00	70070-20014-105	
	70.00	70070-20014-108	
V300-2-50-SA0140 (NOTES 7 AND 9)	72.00	70216-02401-126	NOTE 6
	72.00	70216-02402-129	
	98.00	70217-02705-107	
V300-2-100-SA0140 (NOTE 7)	0.75	70500-02063-153	NOTE 6
V300-1(80)-75-SA0145 (NOTE 8)	3.81	70217-01003-159	NOTE 6
	14.28	70217-01003-161	
V300-2-75-SA0145 (NOTE 8)	3.81	70217-01003-158	NOTE 6
	14.28	70217-01003-160	
V300-1(65)-50 (NOTE 10)	13.0	70070-20013-108	NOTE 6
	23.0	70070-20013-110	

FIGURE H-32. VELCRO TAPE (SHEET 2 OF 4)

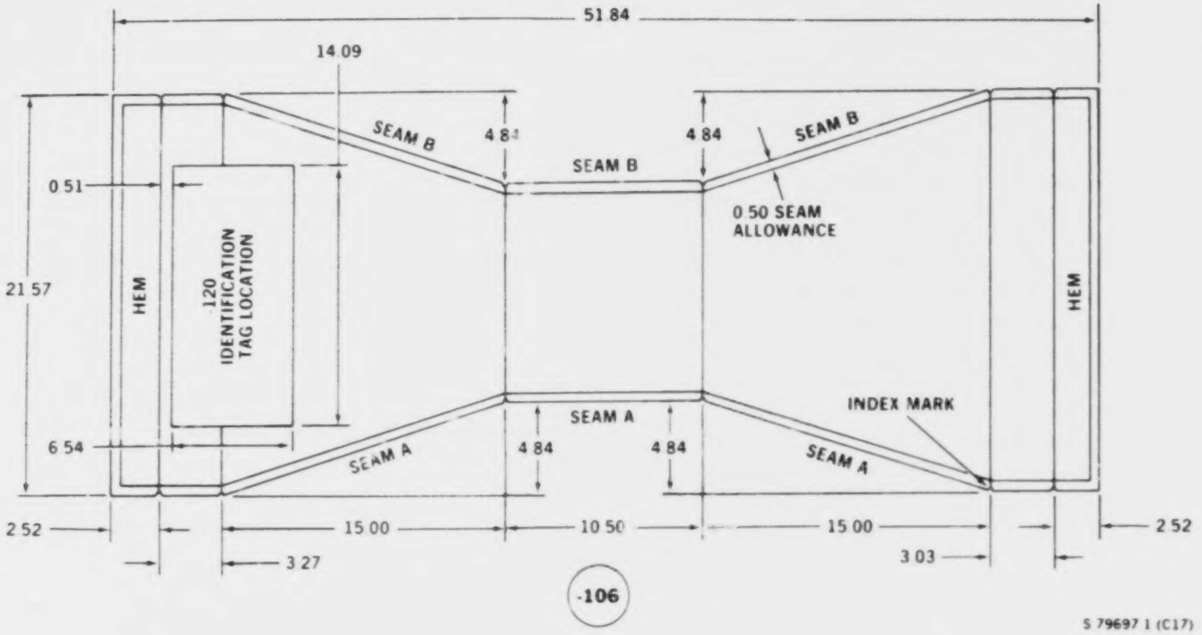
VELCRO TAPE PART NUMBER	LENGTH (L)	SIKORSKY PART NUMBER	NSN
	19.0	70070-20013-112	
	19.0	70070-20013-114	
	6.5	70070-20013-116	
	3.0	70070-20013-118	
	9.5	70070-20013-120	
	6.0	70070-20013-122	
	8.0	70070-20013-124	
	35.0	70070-20013-126	
	1.75	70070-20013-134	
	3.0	70070-20013-151	
V330-1(65)-100	4.0	70215-02312-105	NOTE 6
V330-1(80)-50 (NOTE 11)	–	–	8315-00-935-6761
V330-1(80)-100	–	–	8315-00-935-6761
V330-1(80)-200	–	–	8315-00-926-4931
V330-2-50 (NOTE 12)	13.0	70070-20013-107	8315-00-978-0113
	23.0	70070-20013-109	
	19.0	70070-20013-111	
	19.0	70070-20013-113	
	6.5	70070-20013-115	
	3.0	70070-20013-117	
	9.5	70070-20013-119	
	6.0	70070-20013-121	
	8.0	70070-20013-123	
	35.0	70070-20013-125	
	1.75	70070-20013-133	
	44.0	70070-20013-137	
	36.0	70070-20013-138	
	5.0	70070-20013-139	
	3.5	70070-20013-140	
	21.0	70070-20013-141	
	3.0	70070-20013-150	
V330-2-63	–	–	8315-00-935-6763
V330-2-75	–	–	8315-00-066-5054
V330-2-200 (NOTE 13)	4.0	70215-02312-104	8315-00-978-0113

FIGURE H-32. VELCRO TAPE (SHEET 3 OF 4)

NOTES:

1. MAKE VELCRO TAPE STRIPS, AS REQUIRED, USING MATERIAL AND DIMENSIONS LISTED IN CHART.
2. ALL DIMENSIONS ARE IN INCHES.
3. MAKE FROM V300-1(65)-100.
4. MAKE FROM TWO STRIPS OF V300-1(65)-75.
5. MAKE FROM TWO STRIPS OF V300-2-75.
6. MADE BY HARTWELL CO., FSCM 83014.
7. SOLVENT-ACTIVATED ADHESIVE-BACKED TAPE FOR BONDING TO POROUS SURFACES.
8. SOLVENT-ACTIVATED ADHESIVE-BACKED TAPE FOR BONDING TO METAL SURFACES.
9. MAKE FROM V300-2-100-SA0140.
10. MAKE FROM V330-1(65)-100.
11. MAKE FROM V330-1(80)-100.
12. MAKE FROM V330-2-100.
13. MAKE FROM TWO STRIPS OF V330-2-100.
14. ATTACH VELCRO STRIPS, AS SPECIFIED. BOND OR SEW TAPE IN PLACE PER TM 55-1500-204-25/1 AND FED-STD-751.
15. IDENTIFY PARTS PER MIL-STD-130.

FIGURE H-32. VELCRO TAPE (SHEET 4 OF 4)


51.84
14.09
SEAM B
4.84
SEAM B
4.84
SEAM B
0.50 SEAM ALLOWANCE
0.51
21.57
HEM
-120 IDENTIFICATION TAG LOCATION
HEM
INDEX MARK
SEAM A
6.54
SEAM A
4.84
4.84
SEAM A
2.52
15.00
10.50
15.00
2.52
3.27
3.03
-106
S 79697 1 (C17)

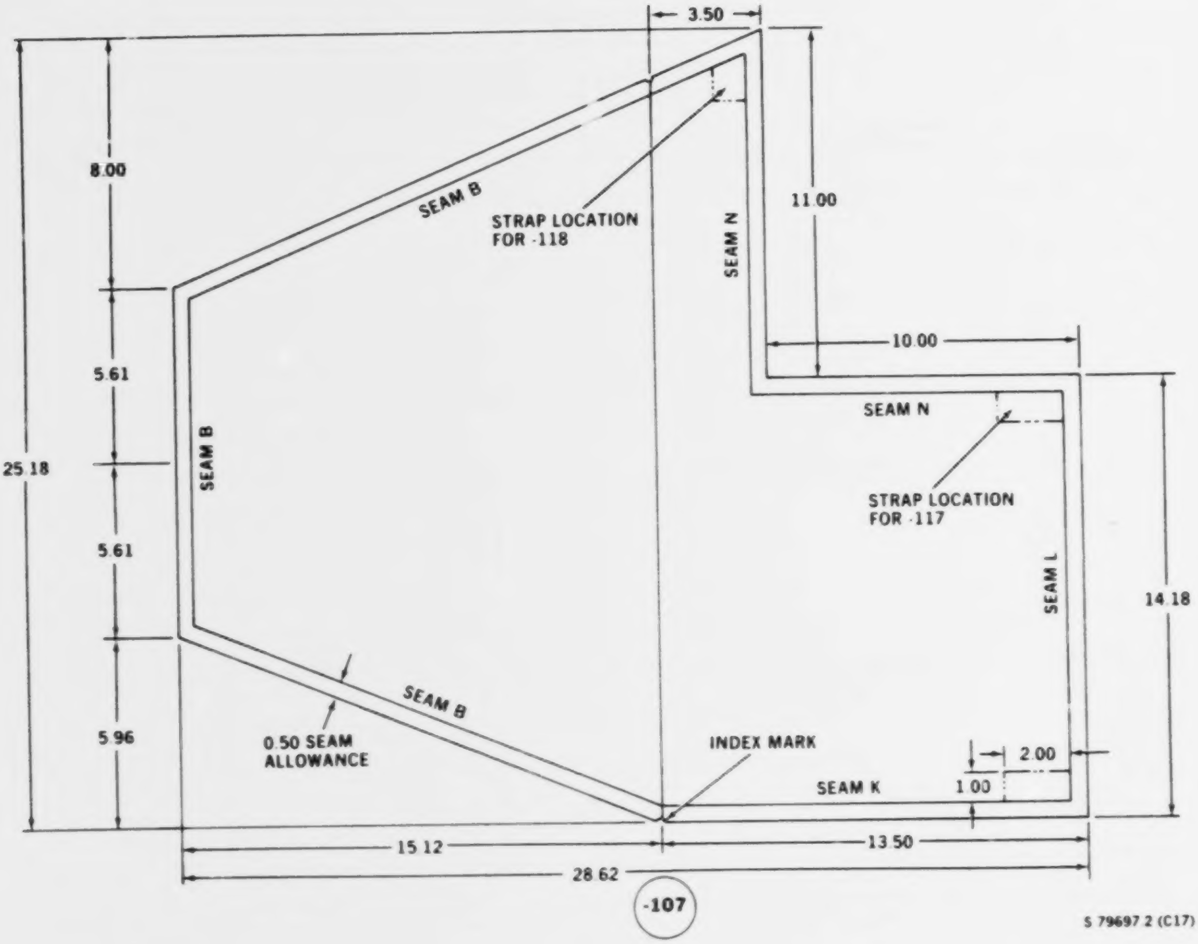
NOMENCLATURE	SIKORSKY PART NUMBER
OIL COOLER COVER ASSEMBLY	70700-20511-106

NOTES

1. MAKE FROM OLIVE DRAB VINYL COATED NYLON CLOTH, MIL-C-20696, TYPE 1, CLASS 2, NSN 8305-00-286-7034
2. ALL DIMENSIONS ARE IN INCHES, ±0.010 INCH
3. IDENTIFY PARTS PER MIL-STD-130
4. ALL SEAMS AND STITCHING TO BE IN ACCORDANCE WITH FED-STD-751 AND TM 55-1500-204-25/1

PART NUMBER 70700-20511-106 OIL COOLER COVER ASSEMBLY

FIGURE H-33. OIL COOLER COVER ASSEMBLY (SHEET 1 OF 13)


3.50
8.00
SEAM B
STRAP LOCATION
FOR -118
SEAM N
11.00
10.00
5.61
25.18
SEAM B
SEAM N
STRAP LOCATION
FOR -117
5.61
SEAM L
14.18
SEAM B
5.96
0.50 SEAM
ALLOWANCE
INDEX MARK
2.00
SEAM K
1.00
15.12
13.50
28.62
-107
S 79697.2 (C17)

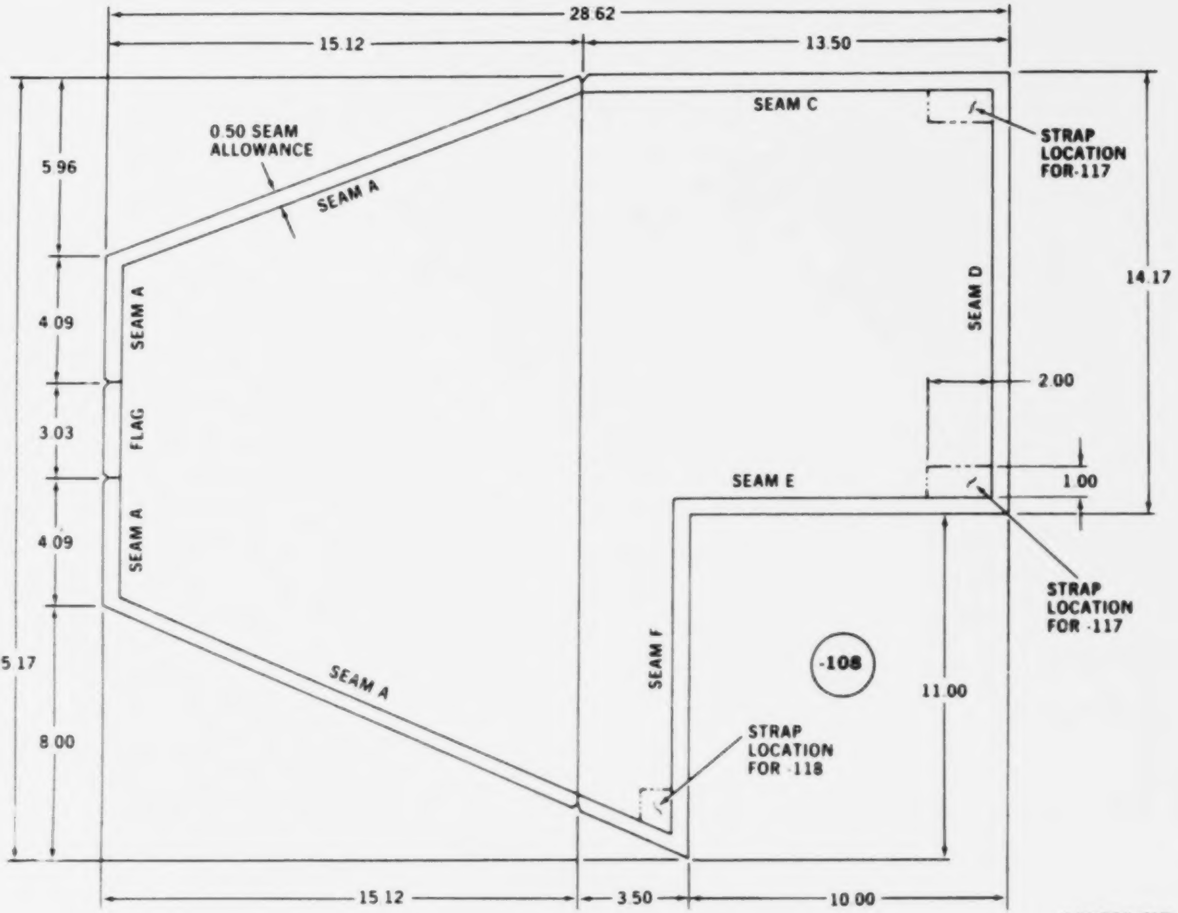
NOMENCLATURE	SIKORSKY PART NUMBER
OIL COOLER COVER ASSEMBLY	70700-20511-107

NOTES:

1. MAKE FROM OLIVE DRAB VINYL COATED NYLON CLOTH, MIL-C-20696, TYPE I, CLASS 2, NSN 8305-00-286-7034.
2. ALL DIMENSIONS ARE IN INCHES, ± 0.010 INCH.
3. IDENTIFY PARTS PER MIL-STD-130.
4. ALL SEAMS AND STITCHING TO BE IN ACCORDANCE WITH FED-STD-751 AND TM 55-1500-204-25/1.

PART NUMBER: 70700-20511-107 OIL COOLER COVER ASSEMBLY.

FIGURE H-33. OIL COOLER COVER ASSEMBLY (SHEET 2 OF 13)


28.62
15.12
13.50
5.96
0.50 SEAM ALLOWANCE
SEAM A
SEAM C
STRAP LOCATION FOR-117
SEAM D
14.17
4.09
SEAM A
2.00
3.03
FLAG
1.00
SEAM E
4.09
SEAM A
STRAP LOCATION FOR -117
25.17
SEAM F
-108
SEAM A
11.00
8.00
STRAP LOCATION FOR -118
15.12
3.50
10.00

S 79697 3 (C17)

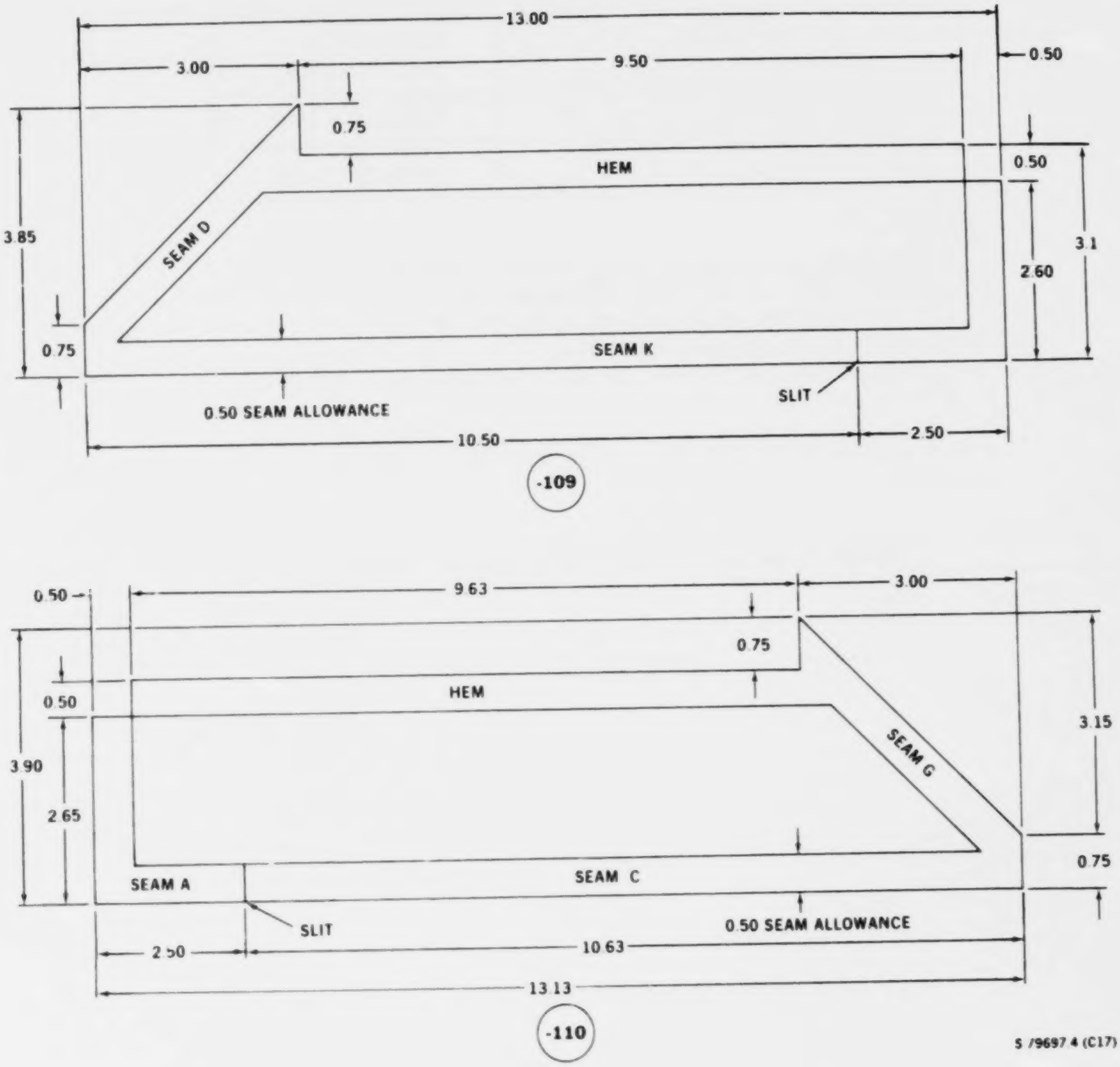
NOMENCLATURE	SIKORSKY PART NUMBER
OIL COOLER COVER ASSEMBLY	70700-20511-108

NOTES:

1. MAKE FROM OLIVE DRAB VINYL COATED NYLON CLOTH, MIL-C-20696, TYPE I, CLASS 2, NSN 8305-00-286-7034.
2. ALL DIMENSIONS ARE IN INCHES, ±0.010 INCH.
3. IDENTIFY PARTS PER MIL-STD-130.
4. ALL SEAMS AND STITCHING TO BE IN ACCORDANCE WITH FED-STD-751 AND TM 55-1500-204-25/1.

PART NUMBER: 70700-20511-108 OIL COOLER COVER ASSEMBLY.

FIGURE H-33. OIL COOLER COVER ASSEMBLY (SHEET 3 OF 13)


13.00
3.00
9.50
0.50
0.75
0.50
HEM
3.85
SEAM D
3.1
2.60
0.75
SEAM K
SLIT
0.50 SEAM ALLOWANCE
10.50
2.50
-109
0.50
9.63
3.00
0.75
0.50
HEM
3.15
3.90
2.65
SEAM G
0.75
SEAM A
SEAM C
SLIT
0.50 SEAM ALLOWANCE
2.50
10.63
13.13
-110

S /9697.4 (C17)

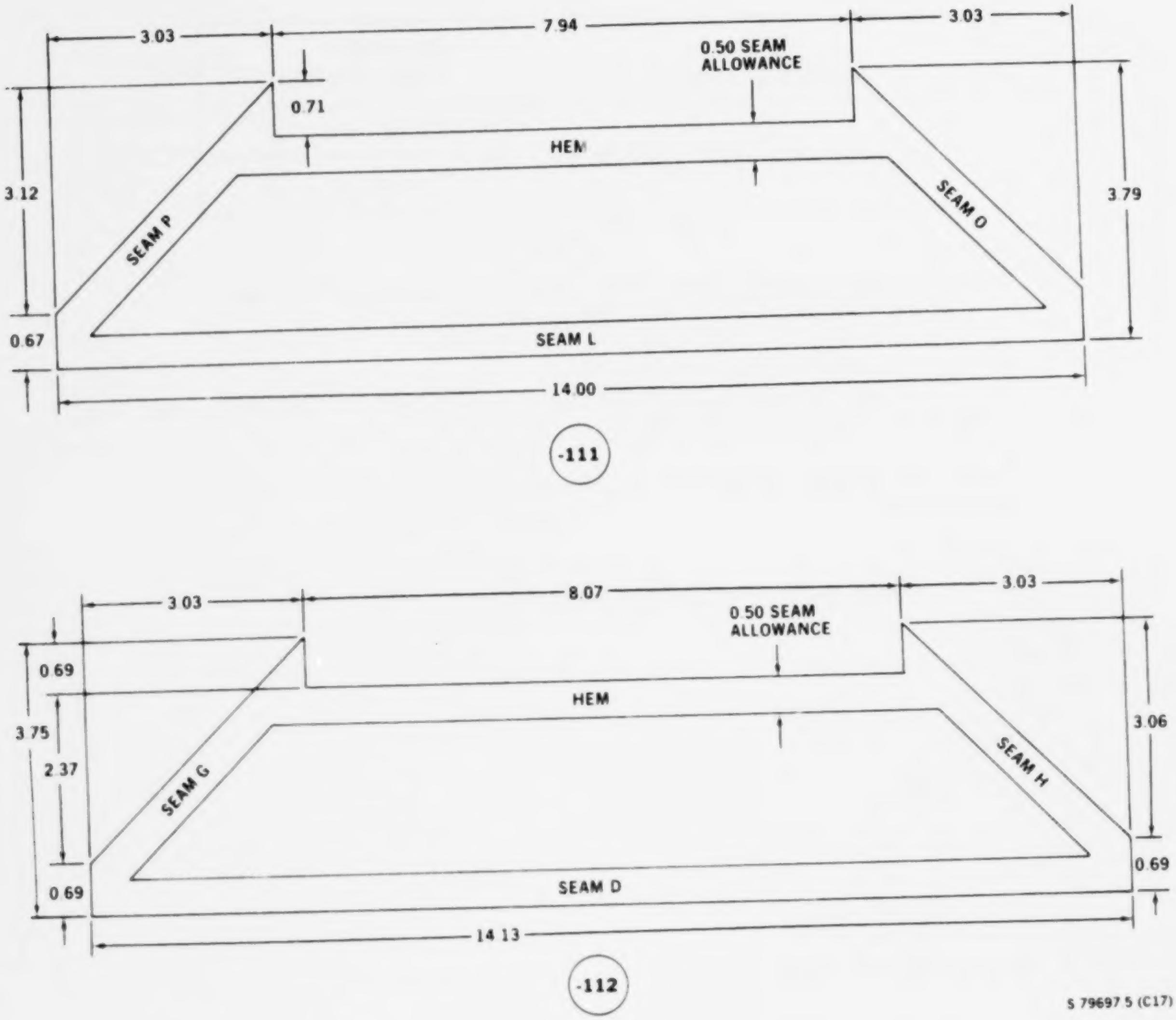
FIGURE H-33. OIL COOLER COVER ASSEMBLY (SHEET 4 OF 13)

NOMENCLATURE	SIKORSKY PART NUMBER
OIL COOLER COVER ASSEMBLY	70700-20511-109
	70700-20511-110

NOTES:
1. MAKE FROM OLIVE DRAB VINYL COATED NYLON CLOTH, MIL-C-20696, TYPE 1, CLASS 2, NSN 8305-00-286-7034.
2. ALL DIMENSIONS ARE IN INCHES, ±0.010 INCH.
3. IDENTIFY PARTS PER MIL-STD-130.
4. ALL SEAMS AND STITCHING TO BE IN ACCORDANCE WITH FED-STD-751 AND TM 55-1500-204-25/1.

PART NUMBER: 70700-20511-109, -110 OIL COOLER COVER ASSEMBLY.

FIGURE H-33. OIL COOLER COVER ASSEMBLY (SHEET 5 OF 13)


3.03
7.94
3.03
0.50 SEAM ALLOWANCE
0.71
HEM
3.12
3.79
SEAM P
SEAM O
0.67
SEAM L
14.00
-111
3.03
8.07
3.03
0.50 SEAM ALLOWANCE
0.69
HEM
3.75
2.37
3.06
SEAM G
SEAM H
0.69
0.69
SEAM D
14.13
-112

S 79697.5 (C17)

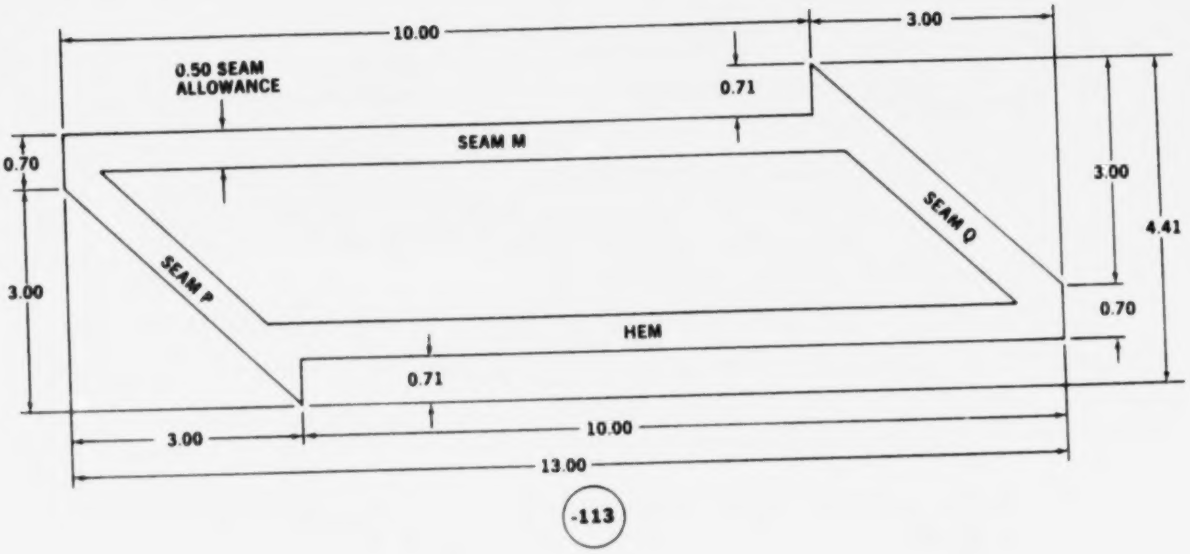
FIGURE H-33. OIL COOLER COVER ASSEMBLY (SHEET 6 OF 13)

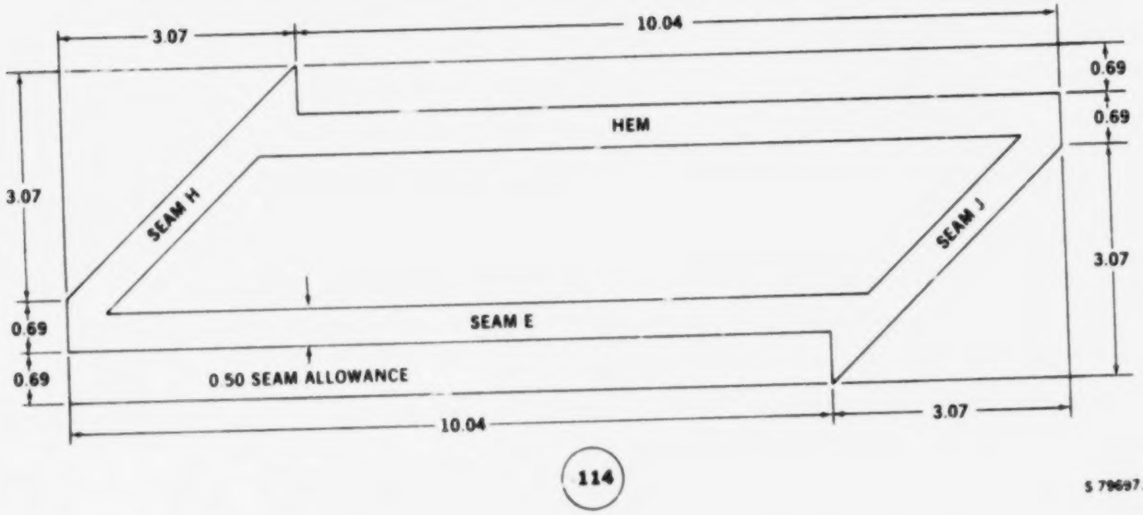
NOMENCLATURE	SIKORSKY PART NUMBER
OIL COOLER COVER ASSEMBLY	70700-20511-111
	70700-20511-112

NOTES:
1. MAKE FROM OLIVE DRAB VINYL COATED NYLON CLOTH, MIL-C-20696, TYPE I, CLASS 2, NSN 8305-00-286-7034.
2. ALL DIMENSIONS ARE IN INCHES, ±0.010 INCH.
3. IDENTIFY PARTS PER MIL-STD-130.
4. ALL SEAMS AND STITCHING TO BE IN ACCORDANCE WITH FED-STD-751 AND TM 55-1500-204-25/1.

PART NUMBER: 70700-20511-111, -112 OIL COOLER COVER ASSEMBLY.

FIGURE H-33. OIL COOLER COVER ASSEMBLY (SHEET 7 OF 13)


10.00
3.00
0.50 SEAM ALLOWANCE
0.71
0.70
SEAM M
SEAM Q
3.00
4.41
SEAM P
3.00
0.70
HEM
0.71
3.00
10.00
13.00
-113


3.07
10.04
0.69
0.69
HEM
3.07
SEAM H
SEAM J
3.07
0.69
SEAM E
0.69
0.50 SEAM ALLOWANCE
10.04
3.07
114

S 79697.6 (C17)

FIGURE H-33. OIL COOLER COVER ASSEMBLY (SHEET 8 OF 13)

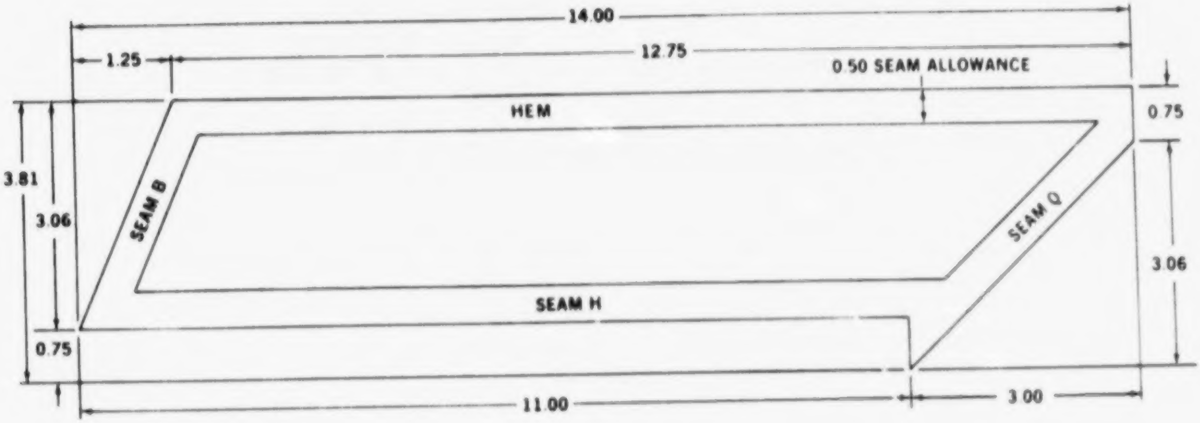
NOMENCLATURE	SIKORSKY PART NUMBER
OIL COOLER COVER ASSEMBLY	70700-20511-113
	70700-20511-114

NOTES:

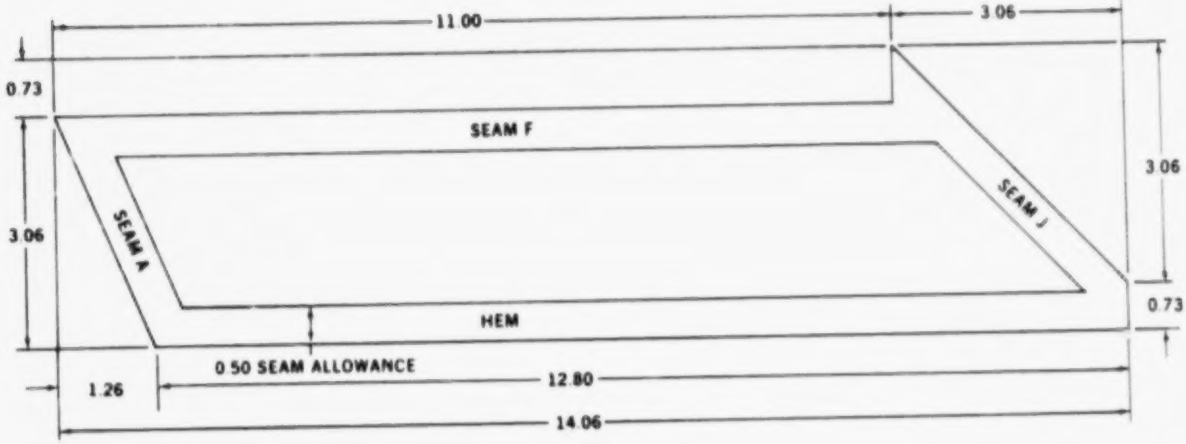
1. MAKE FROM OLIVE DRAB VINYL COATED NYLON CLOTH, MIL-C-20696, TYPE I, CLASS 2, NSN 8305-00-286-7034.
2. ALL DIMENSIONS ARE IN INCHES, ± 0.010 INCH.
3. IDENTIFY PARTS PER MIL-STD-130.
4. ALL SEAMS AND STITCHING TO BE IN ACCORDANCE WITH FED-STD-751 AND TM 55-1500-204-25/1.

PART NUMBER: 70700-20511-113, -114 OIL COOLER COVER ASSEMBLY

FIGURE H-33. OIL COOLER COVER ASSEMBLY (SHEET 9 OF 13)


14.00
1.25
12.75
0.50 SEAM ALLOWANCE
HEM
0.75
3.81
3.06
SEAM B
SEAM Q
3.06
SEAM H
0.75
11.00
3.00

-115


11.00
3.06
0.73
SEAM F
3.06
SEAM J
3.06
SEAM A
HEM
0.73
0.50 SEAM ALLOWANCE
1.26
12.80
14.06

-116

S 79697 7 (C17)

FIGURE H-33. OIL COOLER COVER ASSEMBLY (SHEET 10 OF 13)

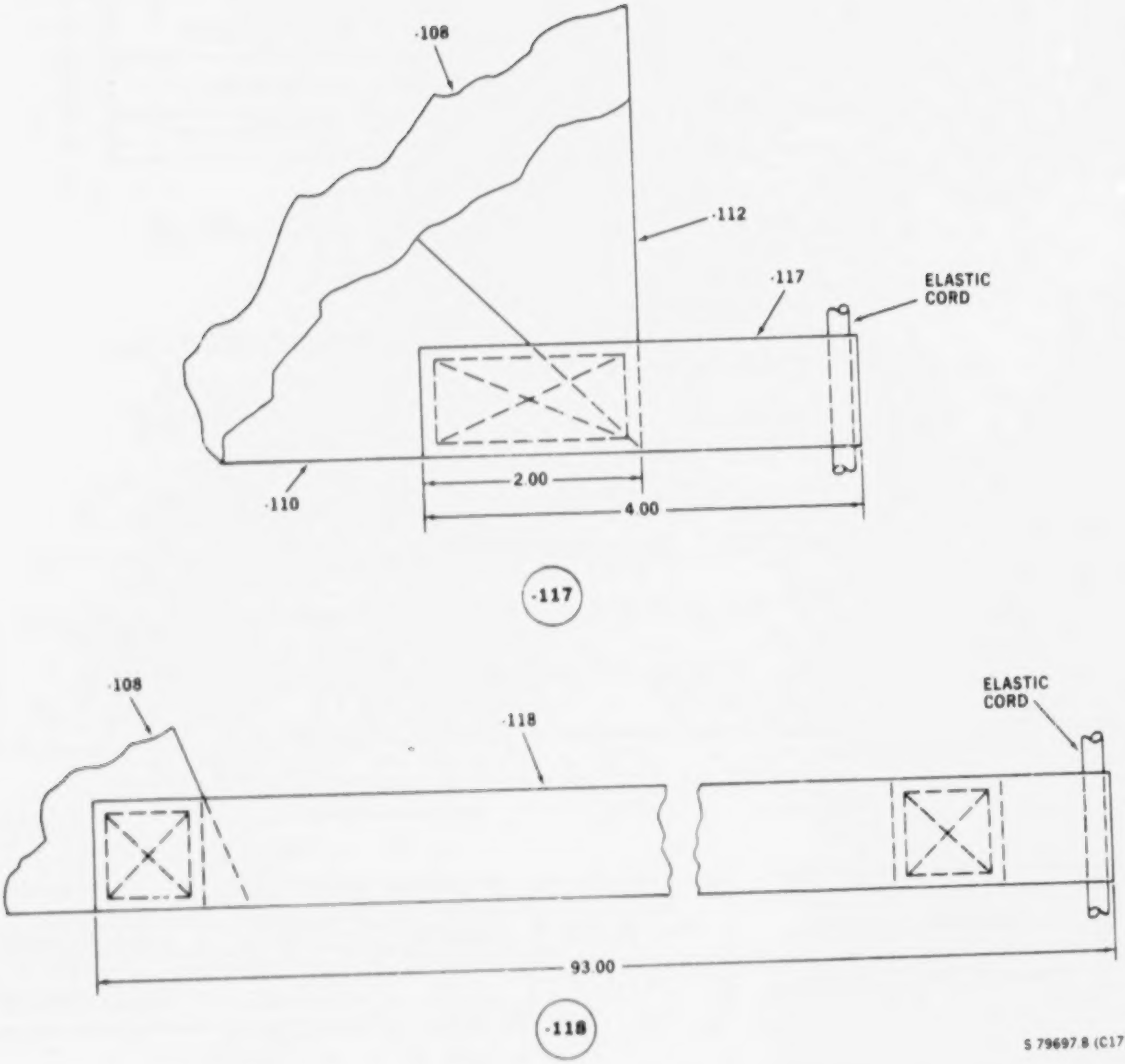
NOMENCLATURE	SIKORSKY PART NUMBER
OIL COOLER COVER ASSEMBLY	70700-20511-115
	70700-20511-116

NOTES:

1. MAKE FROM OLIVE DRAB VINYL COATED NYLON CLOTH, MIL-C-20696, TYPE I, CLASS 2, NSN 8305-00-286-7034.
2. ALL DIMENSIONS ARE IN INCHES, ±0.010 INCH.
3. IDENTIFY PARTS PER MIL-STD-130.
4. ALL SEAMS AND STITCHING TO BE IN ACCORDANCE WITH FED-STD-751 AND TM 55-1500-204-25/1.

PART NUMBER: 70700-20511-115, -116 OIL COOLER COVER ASSEMBLY.

FIGURE H-33. OIL COOLER COVER ASSEMBLY (SHEET 11 OF 13)


-108
-112
-117
ELASTIC CORD
-110
2.00
4.00
-117
-108
-118
ELASTIC CORD
93.00
-118

S 79697.8 (C17)

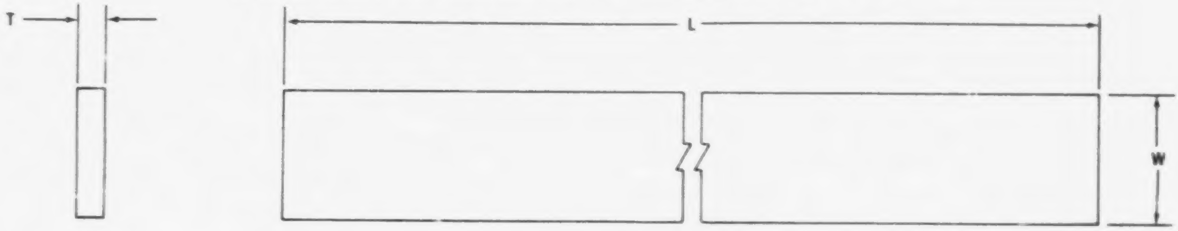
FIGURE H-33. OIL COOLER COVER ASSEMBLY (SHEET 12 OF 13)

NOMENCLATURE	SIKORSKY PART NUMBER
OIL COOLER COVER ASSEMBLY	70700-20511-117
	70700-20511-118

NOTES:
1. MAKE FROM OLIVE DRAB VINYL COATED NYLON CLOTH, MIL-C-20696, TYPE 1, CLASS 2, NSN 8305-00-286-7034.
2. ALL DIMENSIONS ARE IN INCHES, ±0.010 INCH.
3. IDENTIFY PARTS PER MIL-STD-130.
4. ALL SEAMS AND STITCHING TO BE IN ACCORDANCE WITH FED-STD-751 AND TM 55-1500-204-25/1.

PART NUMBER: 70700-20511-117, -118 OIL COOLER COVER ASSEMBLY STRAP.

FIGURE H-33. OIL COOLER COVER ASSEMBLY (SHEET 13 OF 13)



S 79698 (C17)

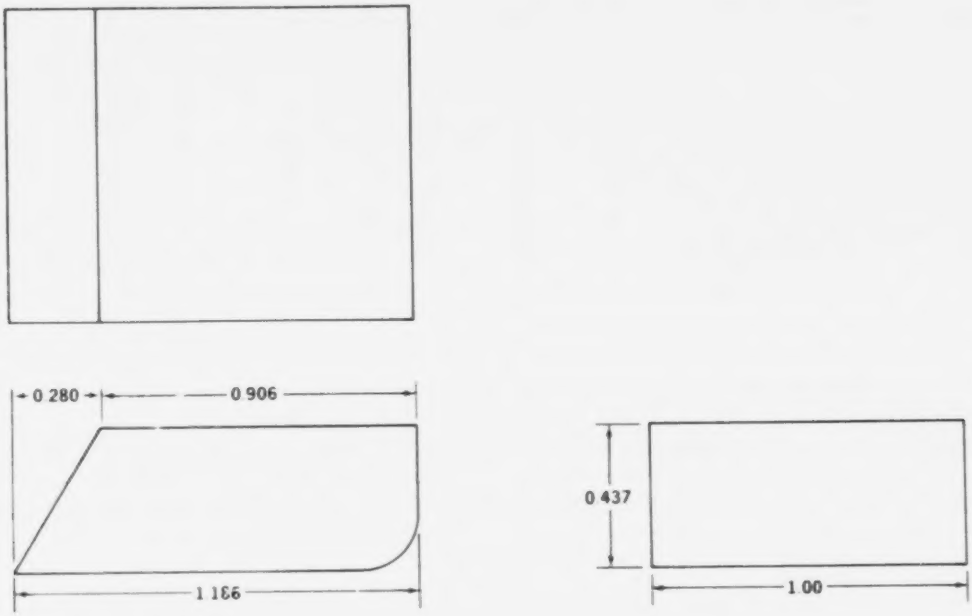
NOMENCLATURE	T THICKNESS	W WIDTH	L LENGTH	SIKORSKY PART NUMBER
GUNNER'S WINDOW SEAL	0.125	0.69	36.44	70216-02402-139

NOTES:
1. MAKE FROM RUBBER, MIL-R-6130, GRADE A, TYPE 1, 0.125 INCH THICK, NSN 9320-00-291-0416.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70216-02402-139 GUNNER'S WINDOW SEAL.

FIGURE H-34. GUNNER'S WINDOW SEAL



S 79699 (C17)

NOMENCLATURE	SIKORSKY PART NUMBER
GUNNER'S WINDOW SEAL	70216-02401-122

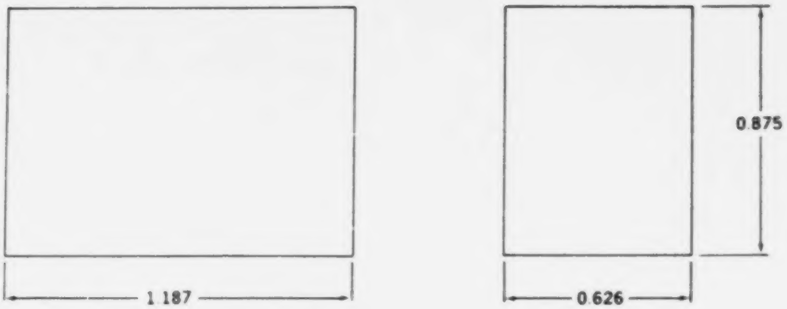
NOTES:

1. MAKE FROM NEOPRENE, MIL-R-6855, CLASS 2, GRADE 60, 0.437 INCH THICK, NSN 9320-00-800-1819.
2. ALL DIMENSIONS ARE INCHES.
3. IDENTIFY PART PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70216-02401-122 GUNNER'S WINDOW SEAL.

FIGURE H-35. GUNNER'S WINDOW SEAL



S 79700 (C17)

NOMENCLATURE	SIKORSKY PART NUMBER
GUNNER'S WINDOW SEAL	70216-02401-121

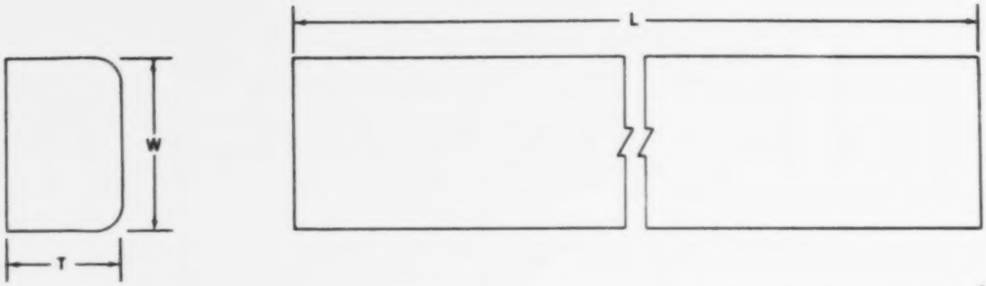
NOTES:

1. MAKE FROM NEOPRENE, MIL-R-6855, CLASS 2, GRADE 60, 0.626 INCH THICK, NSN 9320-00-241-9766.
2. ALL DIMENSIONS ARE INCHES.
3. IDENTIFY PART PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70216-02401-121 GUNNER'S WINDOW SEAL.

FIGURE H-36. GUNNER'S WINDOW SEAL



S 79701 (C17)

NOMENCLATURE	T THICKNESS	W WIDTH	L LENGTH	SIKORSKY PART NUMBER
GUNNER'S WINDOW SEAL	0.250	0.375	35.04	70216-02401-110

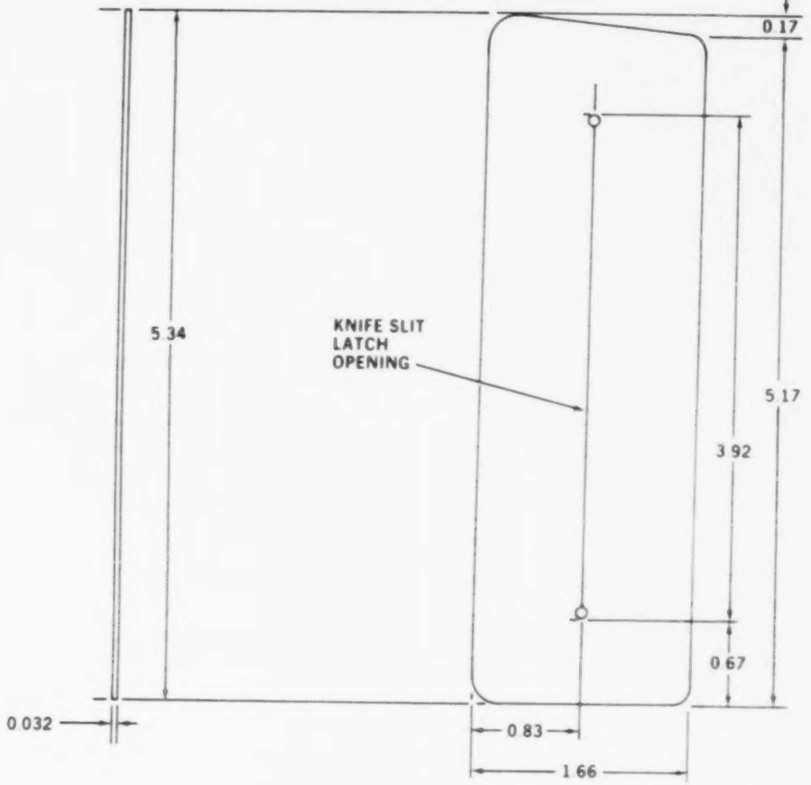
NOTES:

1. MAKE FROM SILICONE SPONGE RUBBER, S6105-2108-2, NSN 5330-00-804-6813.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: $\underbrace{\text{P/N 70216-02401-107}}_{\text{PART NUMBER}}$ $\underbrace{\text{3Q}}_{\text{THIRD QUARTER}}$ $\underbrace{\text{86}}_{\text{1986}}$

PART NUMBER: 70216-02401-110 GUNNER'S WINDOW SEAL.

FIGURE H-37. GUNNER'S WINDOW SEAL


0.17
5.34
KNIFE SLIT
LATCH
OPENING
5.17
3.92
0.67
0.032
0.83
1.66

S 79703 (C17)

FIGURE H-38. GUNNER'S WINDOW LATCH SEAL (SHEET 1 OF 2)

NOMENCLATURE	SIKORSKY PART NUMBER
GUNNER'S WINDOW LATCH SEAL	70216-02402-122

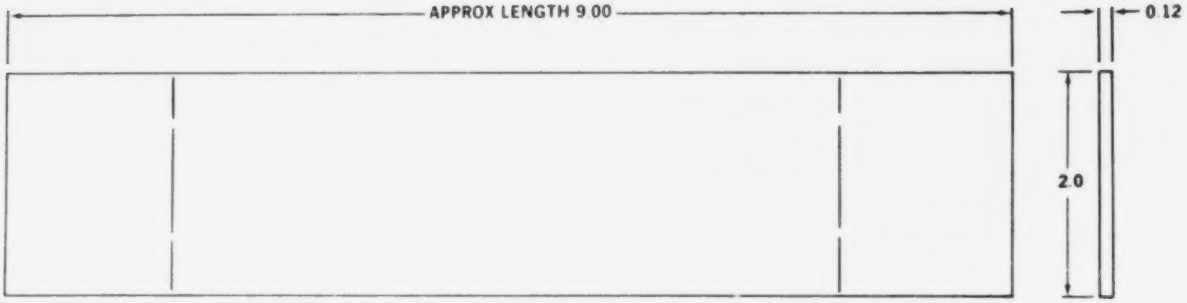
NOTES:

1. MAKE FROM NEOPRENE, MIL-R-6855, CLASS 2, GRADE 60, 0.032 INCH THICK, NSN 9320-01-157-9069.
2. DIMENSIONS ARE IN INCHES.
3. IDENTIFY PART PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70216-02402-122 GUNNER'S WINDOW LATCH SEAL.

FIGURE H-38. GUNNER'S WINDOW LATCH SEAL (SHEET 2 OF 2)



S 79705 (C17)

NOMENCLATURE	SIKORSKY PART NUMBER
CABIN DUCT INSTALLATION GASKETS	70500-02057-159
	70500-02057-160

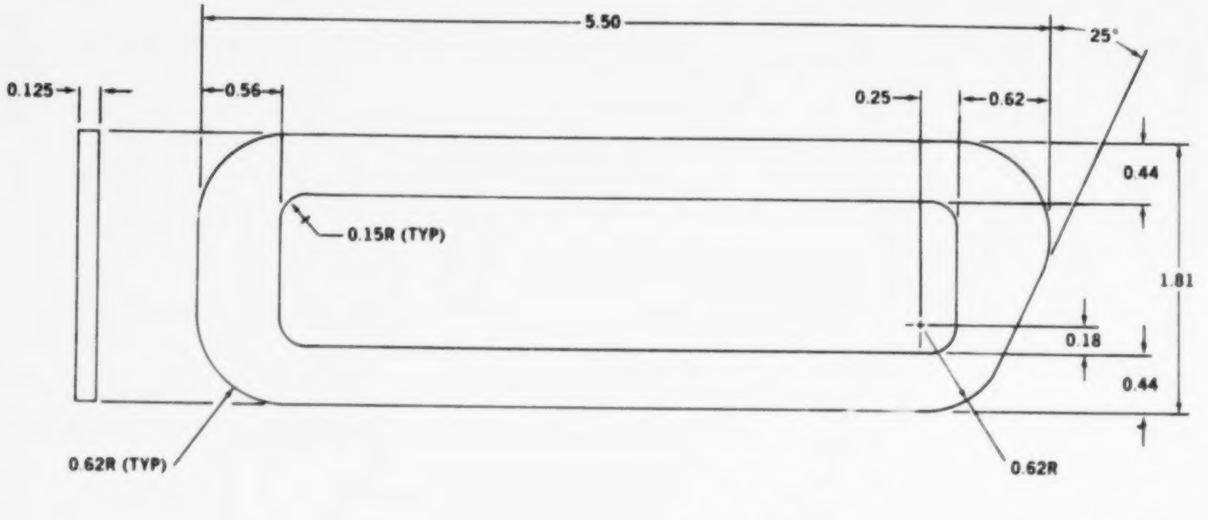
NOTES:
1. MAKE FROM SHEET RUBBER, MIL-R-6130, GRADE A, TYPE 2, SOFT, NSN 9320-00-814-4583.
2. DIMENSIONS ARE IN INCHES.
3. IDENTIFY PART PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GRAY INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

4. TRIM SEAL ON INSTALLATION.

PART NUMBERS: 70500-02057-159, -160 CABIN DUCT INSTALLATION GASKETS.

FIGURE H-39. DUCT INSTALLATION GASKET



S 79706 (C17)

NOMENCLATURE	SIKORSKY PART NUMBER
SIDE WALL DUCT INSTALLATION SEAL	70500-02058-123

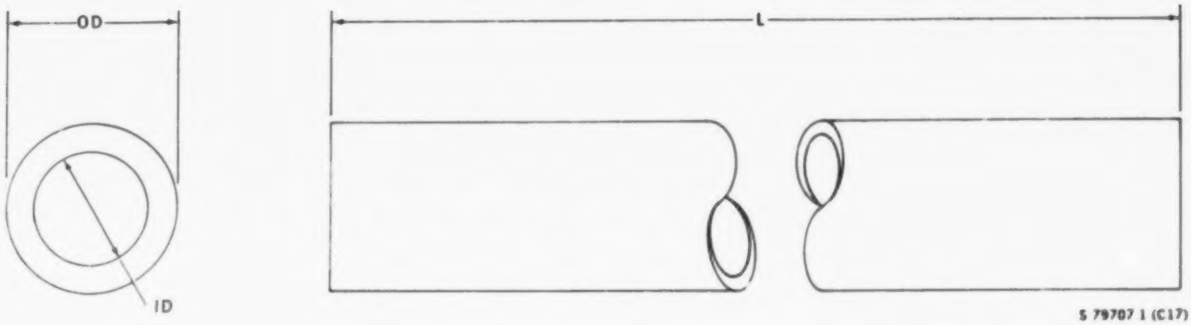
NOTES:

1. MAKE FROM RUBBER SHEET, MIL-R-6855, CLASS 1, GRADE 40, NSN 9320-00-059-6504.
2. DIMENSIONS ARE IN INCHES.
3. IDENTIFY PART PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GRAY INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70500-02058-123 SIDE WALL DUCT INSTALLATION SEAL.

FIGURE H-40. SIDEWALL DUCT INSTALLATION SEAL



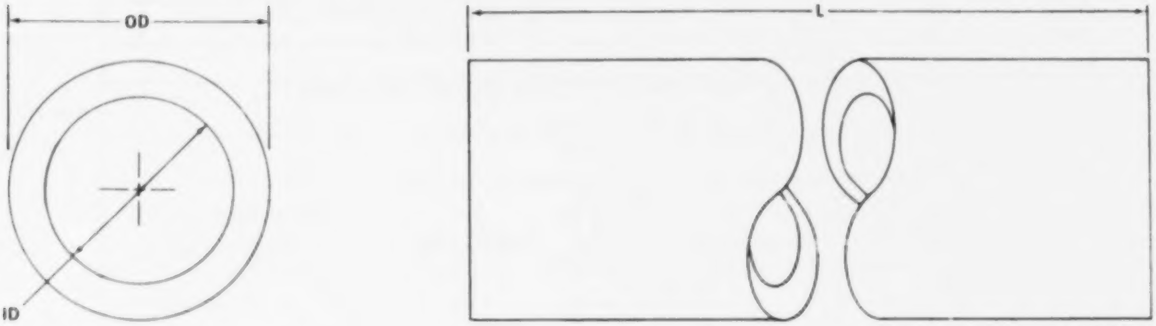
S 79707 1 (C17)

NOMENCLATURE	L LENGTH	OD OUTSIDE DIAMETER	ID INSIDE DIAMETER	SIKORSKY PART NUMBER
URETHANE TUBING	28.00	0.375	0.250	70651-03102-180
	34.00			70651-03102-181
	72.00			70651-03102-182
	40.00			70652-02251-173
	66.00			70652-02251-174
	20.00			70652-02251-175

NOTES:

1. MAKE FROM URETHANE TUBING, NSN 4720-01-004-8081.
2. ALL DIMENSIONS ARE IN INCHES.
3. CUT ENDS STRAIGHT.
4. DO NOT PAINT.
5. IDENTIFY PARTS PER TM 55-1500-204-25/1 (HYDRAULIC DRAIN).

FIGURE H-41. SIDEWALL DUCT INSTALLATION SEAL (SHEET 1 OF 2)

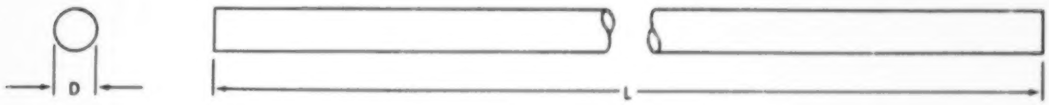


S 79707 2 (C17)

NOMENCLATURE	L LENGTH	OD OUTSIDE DIAMETER	ID INSIDE DIAMETER	SIKORSKY PART NUMBER
URETHANE TUBING	40.00	0.50	0.375	70652-02251-170
	72.00			70652-02251-171
	24.00			70652-02251-172
	2.50			70652-02251-177
	14.0			70652-02251-178
	14.0			70652-02251-179
	76.0			70652-02251-180

NOTES
1. MAKE FROM URETHANE TUBING, NSN 4720-01-145-6685.
2. ALL DIMENSIONS ARE IN INCHES.
3. CUT ENDS STRAIGHT.
4. DO NOT PAINT.
5. IDENTIFY PARTS PER TM 55-1500-204-25/1 (HYDRAULIC DRAIN).

FIGURE H-41. SIDEWALL DUCT INSTALLATION SEAL (SHEET 2 OF 2)



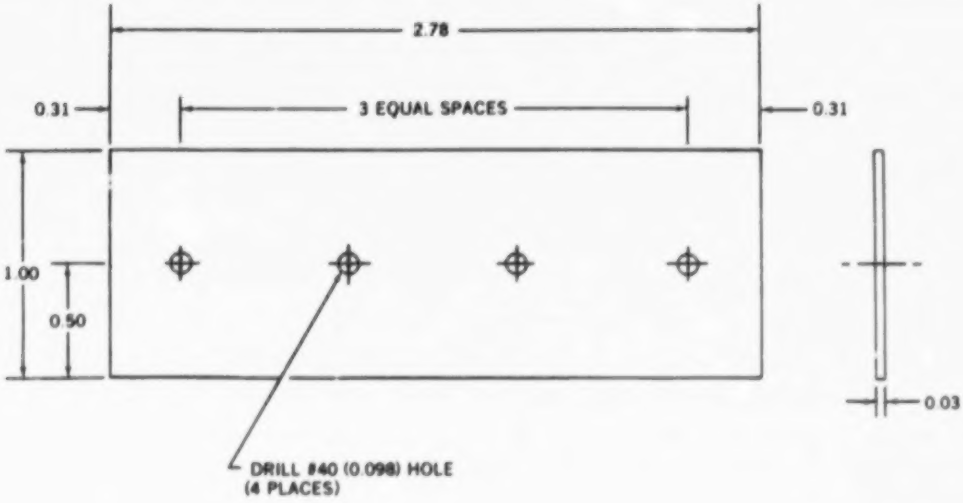
S 79708 (C17)

NOMENCLATURE	D DIAMETER	L LENGTH	SIKORSKY PART NUMBER
ELASTIC CORD	0.187	8.00	70700-20460-103
		25.32	70700-20511-119
		37.29	70700-20511-121

NOTES:
1. MAKE FROM ELASTIC CORD, MIL-C-5651, TYPE 3, NSN 8305-00-267-3116.
2. ALL DIMENSIONS ARE IN INCHES

PART NUMBER: 70700-20460-103, 70700-20511-119, -121 ELASTIC CORD

FIGURE H-42. ELASTIC CORD


2.78
0.31
3 EQUAL SPACES
0.31
1.00
0.50
0.03
DRILL #40 (0.098) HOLE
(4 PLACES)

S 79709 (C17)

NOTES:

1. MAKE FROM 0.032 THICK 7075-T6 ALCLAD SHEET, QQ-A-250/13, NSN 9535-00-232-7535.
2. ALL DIMENSIONS ARE IN INCHES.
3. DRILL HOLES, AS SHOWN IN FIGURE, PER TM 55-1500-204-25/1.
4. BREAK SHARP EDGES AND DEBURR HOLES.
5. CHEMICAL SURFACE TREAT DRILLED HOLES AND CUT EDGES WITH CORROSION RESISTANT COMPOUND (ALODINE) MIL-C-5541, NSN 8030-00-811-3723.
6. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 70217-01003-194 CREW DOOR STRAP.

FIGURE H-43. STRAP

	NOMENCLATURE	LENGTH	TYPE		OD	GAGE	SIKORSKY PART NUMBER	NSN
			END A	END B				
**	TUBE, HYDRAULIC, APU RESERVOIR RETURN	54.50	4	4	0.250	0.016	70652-02252-149	4710-01-105-6616
*	TUBE, HYDRAULIC, APU RECHARGE	25.00	4	6	0.250	0.020	70652-02252-172	4710-01-102-6413
*	TUBE, HYDRAULIC, APU RESERVOIR RETURN	25.00	4	4	0.250	0.016	70652-02252-174	4710-01-105-6616
*	TUBE, HYDRAULIC, APU RESERVOIR RETURN	25.00	4	4	0.250	0.016	70652-02252-175	4710-01-105-6616
*	TUBE, HYDRAULIC, APU RECHARGE PRESSURE	50.00	4	6	0.250	0.016	70652-02252-176	4710-01-105-6616
**	TUBE, HYDRAULIC, 1ST STAGE TRS PRESSURE	49.625	4	4	0.250	0.016	70652-03252-143	4710-01-105-6616
**	TUBE, HYDRAULIC, RETURN 1ST STAGE TRS	49.437	4	4	0.250	0.016	70652-03252-146	4710-01-105-6616
**	TUBE, HYDRAULIC, 1ST STAGE TRS PRESSURE	89.375	4	4	0.250	0.016	70652-03252-149	4710-01-105-6616
**	TUBE, HYDRAULIC, 2ND STAGE TRS RETURN	86.063	4	4	0.250	0.016	70652-03252-153	4710-01-105-6616
**	TUBE, HYDRAULIC, 2ND STAGE TRS RETURN	49.125	4	4	0.250	0.016	70652-03252-158	4710-01-105-6616
**	TUBE, HYDRAULIC, 2ND STAGE TRS PRESSURE	46.750	4	4	0.250	0.016	70652-03252-159	4710-01-105-6616
**	TUBE, HYDRAULIC 1ST STAGE TRS RETURN	40.500	4	4	0.250	0.016	70652-03252-160	4710-01-105-6616

FIGURE H-44. HYDRAULIC TUBING (SHEET 1 OF 9)

	NOMENCLATURE	LENGTH	TYPE		OD	GAGE	SIKORSKY PART NUMBER	NSN
			END A	END B				
**	TUBE, HYDRAULIC, 1ST STAGE TRS PRESSURE	39.125	4	4	0.250	0.016	70652-03252-161	4710-01-105-6616
*	TUBE, HYDRAULIC, 1ST STAGE TRS PRESSURE	85.125	4	4	0.250	0.016	70652-05251-141	4710-01-105-6616
**	TUBE, HYDRAULIC, 1ST STAGE TRS PRESSURE	70.875	4	4	0.250	0.016	70652-05251-143	4710-01-105-6616
**	TUBE, HYDRAULIC, 1ST STAGE TRS RETURN	71.750	4	4	0.250	0.016	70652-05251-144	4710-01-105-6616
*	TUBE, HYDRAULIC, 2ND STAGE TRS PRESSURE	87.00	4	4	0.250	0.016	70652-05251-145	4710-01-105-6616
**	TUBE, HYDRAULIC, 2ND STAGE TRS RETURN	70.437	4	4	0.250	0.016	70652-05251-148	4710-01-105-6616
*	TUBE, HYDRAULIC, TRS RETURN	83.00	4	4	0.250	0.016	70652-05251-149	4710-01-105-6616

*STRAIGHT
**BENT

TUBE ENDS

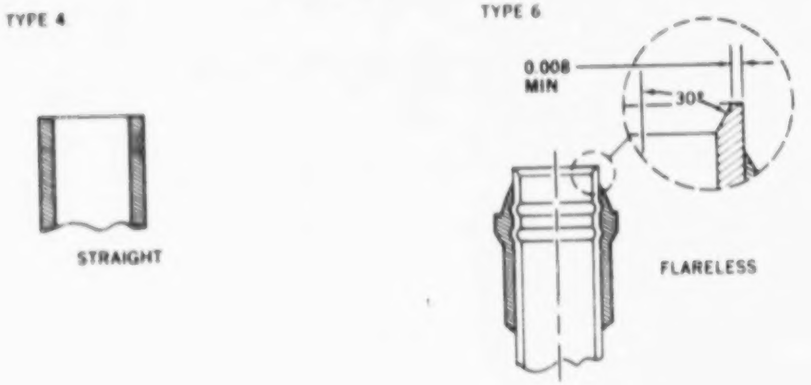


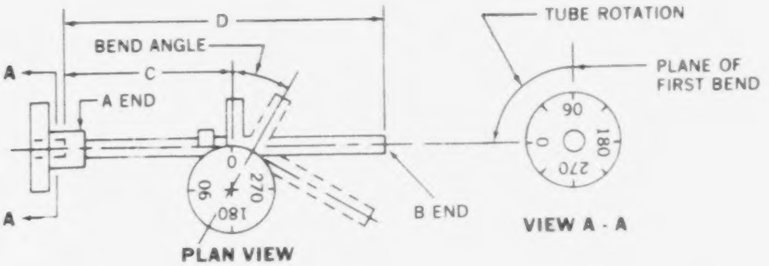
FIGURE H-44. HYDRAULIC TUBING (SHEET 2 OF 9)

TUBE END PARTS

ASSY DASH NO.	TUBE DASH NO.	NSN	END A PART NO.	END A NSN	END B PART NO.	END B NSN	ALT
-072	-172	4710-01-102-6413	—	—	35235VN04 AP2109 MS21921-4J	4730-00-024-4653 4730-00-554-8015 4730-00-919-4651	*
-076	-176	4710-01-105-6616	—	—	35235VN04 AP2109 MS21921-4J	4730-00-024-4653 4730-00-554-8015 4730-00-919-4651	*

*ALTERNATE

BENDS


D
BEND ANGLE
A
C
A END
A
0
270
90
180
B END
PLAN VIEW
TUBE ROTATION
PLANE OF FIRST BEND
90
180
0
270
VIEW A - A

S 79710 2 (C17)

70652-02252-149

BEND NO.	INCHES C	TUBE ROTATION FROM PLAIN OF FIRST BEND COUNTERCLOCK-WISE VIEWED FROM END B, DEGREES	BEND ANGLE DEGREES	BEND NO.	INCHES C	TUBE ROTATION FROM PLAIN OF FIRST BEND COUNTERCLOCK-WISE VIEWED FROM END B, DEGREES	BEND ANGLE DEGREES
1	52.187	0	92				
2	45.125	270	14				
3	22.50	257	30				
4	18.687	80	26				

FIGURE H-44. HYDRAULIC TUBING (SHEET 3 OF 9)

70652-03252-143

BEND NO.	INCHES C	TUBE ROTATION FROM PLAIN OF FIRST BEND COUNTERCLOCK-WISE VIEWED FROM END B, DEGREES	BEND ANGLE DEGREES	BEND NO.	INCHES C	TUBE ROTATION FROM PLAIN OF FIRST BEND COUNTERCLOCK-WISE VIEWED FROM END B, DEGREES	BEND ANGLE DEGREES
1	31.625	0	46				
2	20.125	180	37				

70652-03252-146

BEND NO.	INCHES C	TUBE ROTATION FROM PLAIN OF FIRST BEND COUNTERCLOCK-WISE VIEWED FROM END B, DEGREES	BEND ANGLE DEGREES	BEND NO.	INCHES C	TUBE ROTATION FROM PLAIN OF FIRST BEND COUNTERCLOCK-WISE VIEWED FROM END B, DEGREES	BEND ANGLE DEGREES
1	27.500	0	44				
2	15.875	180	35				

FIGURE H-44. HYDRAULIC TUBING (SHEET 4 OF 9)

70652-03252-149

BEND NO.	INCHES C	TUBE ROTATION FROM PLAIN OF FIRST BEND COUNTERCLOCK-WISE VIEWED FROM END B, DEGREES	BEND ANGLE DEGREES	BEND NO.	INCHES C	TUBE ROTATION FROM PLAIN OF FIRST BEND COUNTERCLOCK-WISE VIEWED FROM END B, DEGREES	BEND ANGLE DEGREES
1	79.562	0	19	5	42.625	302	15
2	70.937	135	37	6	31.063	320	12
3	53.812	321	14	7	13.812	320	25
4	47.687	40	94				

70652-03252-153

BEND NO.	INCHES C	TUBE ROTATION FROM PLAIN OF FIRST BEND COUNTERCLOCK-WISE VIEWED FROM END B, DEGREES	BEND ANGLE DEGREES	BEND NO.	INCHES C	TUBE ROTATION FROM PLAIN OF FIRST BEND COUNTERCLOCK-WISE VIEWED FROM END B, DEGREES	BEND ANGLE DEGREES
1	73.500	0	38	5	20.437	175	28
2	58.681	5	8				
3	44.875	3	15				
4	41.562	281	92				

FIGURE H-44. HYDRAULIC TUBING (SHEET 5 OF 9)

70652-03252-158

BEND NO.	INCHES C	TUBE ROTATION FROM PLAIN OF FIRST BEND COUNTERCLOCK-WISE VIEWED FROM END B, DEGREES	BEND ANGLE DEGREES	BEND NO.	INCHES C	TUBE ROTATION FROM PLAIN OF FIRST BEND COUNTERCLOCK-WISE VIEWED FROM END B, DEGREES	BEND ANGLE DEGREES
1	27.875	0	10				
2	20.000	204	7				
3	10.125	205	14				

70652-03252-159

BEND NO.	INCHES C	TUBE ROTATION FROM PLAIN OF FIRST BEND COUNTERCLOCK-WISE VIEWED FROM END B, DEGREES	BEND ANGLE DEGREES	BEND NO.	INCHES C	TUBE ROTATION FROM PLAIN OF FIRST BEND COUNTERCLOCK-WISE VIEWED FROM END B, DEGREES	BEND ANGLE DEGREES
1	27.125	0	20				
2	19.000	178	15				
3	9.875	209	10				

FIGURE H-44. HYDRAULIC TUBING (SHEET 6 OF 9)

70652-03252-160

BEND NO.	INCHES C	TUBE ROTATION FROM PLAIN OF FIRST BEND COUNTERCLOCK-WISE VIEWED FROM END B, DEGREES	BEND ANGLE DEGREES	BEND NO.	INCHES C	TUBE ROTATION FROM PLAIN OF FIRST BEND COUNTERCLOCK-WISE VIEWED FROM END B, DEGREES	BEND ANGLE DEGREES
1	14.000	0	13				

70652-03252-161

BEND NO.	INCHES C	TUBE ROTATION FROM PLAIN OF FIRST BEND COUNTERCLOCK-WISE VIEWED FROM END B, DEGREES	BEND ANGLE DEGREES	BEND NO.	INCHES C	TUBE ROTATION FROM PLAIN OF FIRST BEND COUNTERCLOCK-WISE VIEWED FROM END B, DEGREES	BEND ANGLE DEGREES
1	11.063	0	13				

FIGURE H-44. HYDRAULIC TUBING (SHEET 7 OF 9)

70652-05251-143

BEND NO.	INCHES C	TUBE ROTATION FROM PLAIN OF FIRST BEND COUNTERCLOCK-WISE VIEWED FROM END B, DEGREES	BEND ANGLE DEGREES	BEND NO.	INCHES C	TUBE ROTATION FROM PLAIN OF FIRST BEND COUNTERCLOCK-WISE VIEWED FROM END B, DEGREES	BEND ANGLE DEGREES
1	69.125	0	42	5	8.250	82	72
2	48.063	180	44	6	4.312	267	154
3	44.000	240	53				
4	33.375	62	56				

70652-05251-144

BEND NO.	INCHES C	TUBE ROTATION FROM PLAIN OF FIRST BEND COUNTERCLOCK-WISE VIEWED FROM END B, DEGREES	BEND ANGLE DEGREES	BEND NO.	INCHES C	TUBE ROTATION FROM PLAIN OF FIRST BEND COUNTERCLOCK-WISE VIEWED FROM END B, DEGREES	BEND ANGLE DEGREES
1	68.812	0	154	5	24.250	74	53
2	64.500	180	70	6	3.000	260	38
3	40.875	201	48				
4	28.937	12	42				

FIGURE H-44. HYDRAULIC TUBING (SHEET 8 OF 9)

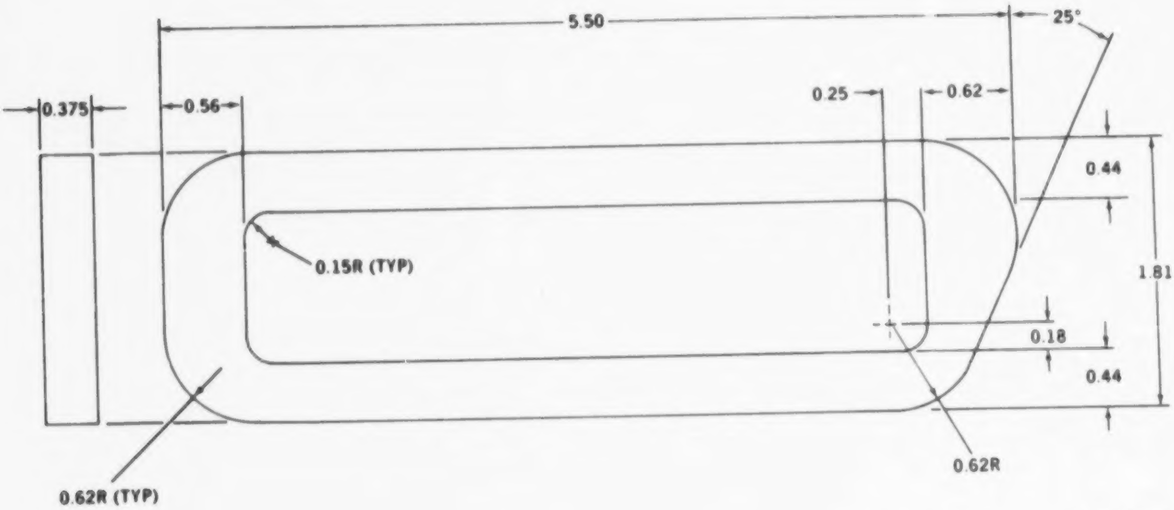
70652-05251-148

BEND NO.	INCHES C	TUBE ROTATION FROM PLAIN OF FIRST BEND COUNTERCLOCK-WISE VIEWED FROM END B, DEGREES	BEND ANGLE DEGREES	BEND NO.	INCHES C	TUBE ROTATION FROM PLAIN OF FIRST BEND COUNTERCLOCK-WISE VIEWED FROM END B, DEGREES	BEND ANGLE DEGREES
1	66.687	0	150				
2	61.562	180	69				
3	19.500	168	75				
4	13.250	340	80				

NOTES:

1. MAKE 0.250-INCH OD, 0.016 GAGE TUBE ASSEMBLIES FROM AMS5561, 21-6-9 STAINLESS STEEL, NSN 4710-01-105-6616. MAKE 0.250-INCH OD, 0.020 GAGE TUBE ASSEMBLIES FROM AMS5561, 21-6-9 STAINLESS STEEL, NSN 4710-01-102-6413.
2. ALL DIMENSIONS ARE IN INCHES.
3. ASSEMBLE END PARTS, BEND AND COLOR CODE TUBE ASSEMBLIES PER TM 55-1500-204-25/1.
4. FLUSH TUBES WITH DRY-CLEANING SOLVENT, FED. SPEC P-D-680 TYPE 2, NSN 6850-00-285-8011.
5. CAP BOTH ENDS BEFORE TRANSPORTING OR STORING.

FIGURE H-44. HYDRAULIC TUBING (SHEET 9 OF 9)


5.50
25°
0.375
0.56
0.25
0.62
0.44
0.15R (TYP)
1.81
0.18
0.44
0.62R (TYP)
0.62R

S 79711 (C17)

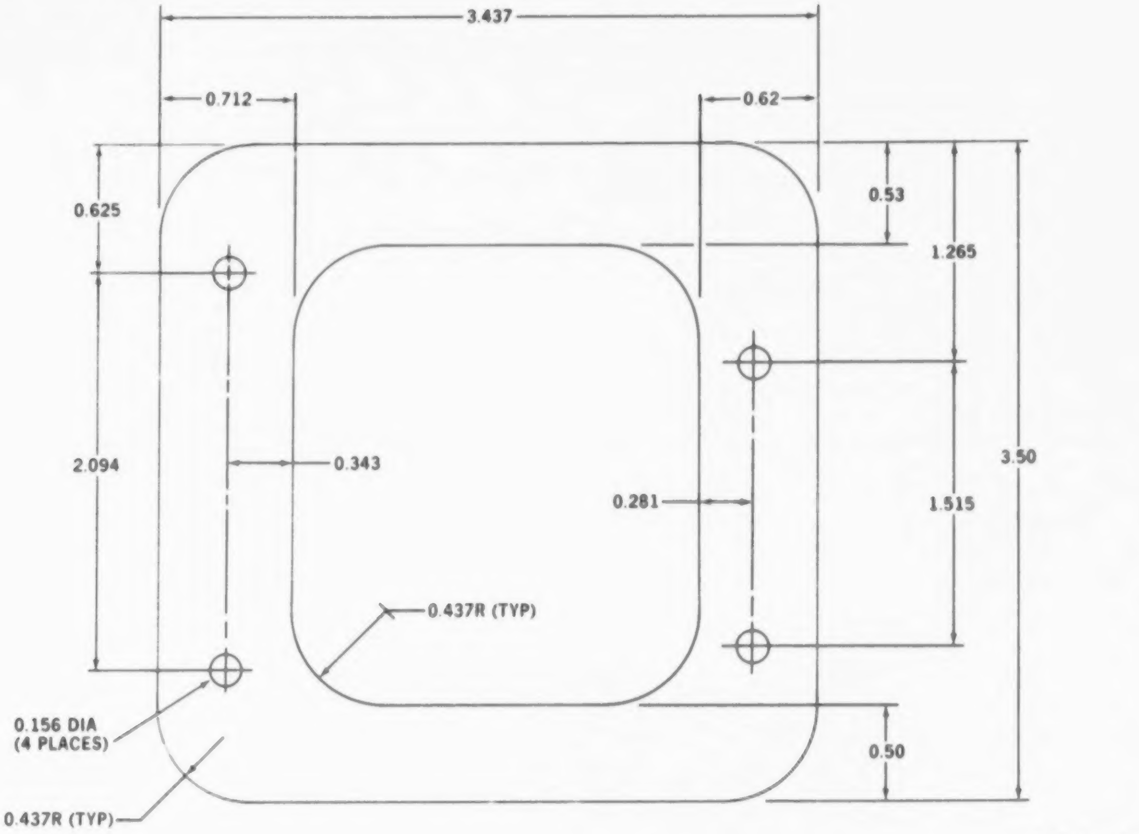
NOTES:

1. MAKE FROM SHEET RUBBER, MIL-R-6130, TYPE 2, GRADE A, SOFT, 0.375 INCH THICK, NSN 5330-00-232-2420.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GRAY INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70500-02058-150 DUCT INSTALLATION SEAL.

FIGURE H-45. DUCT INSTALLATION SEAL


3.437
0.712
0.62
0.625
0.53
1.265
2.094
0.343
0.281
1.515
3.50
0.437R (TYP)
0.156 DIA
(4 PLACES)
0.50
0.437R (TYP)

S 79712 (C17)

NOMENCLATURE	SIKORSKY PART NUMBER
DUCT INSTALLATION SEAL	70500-02058-151

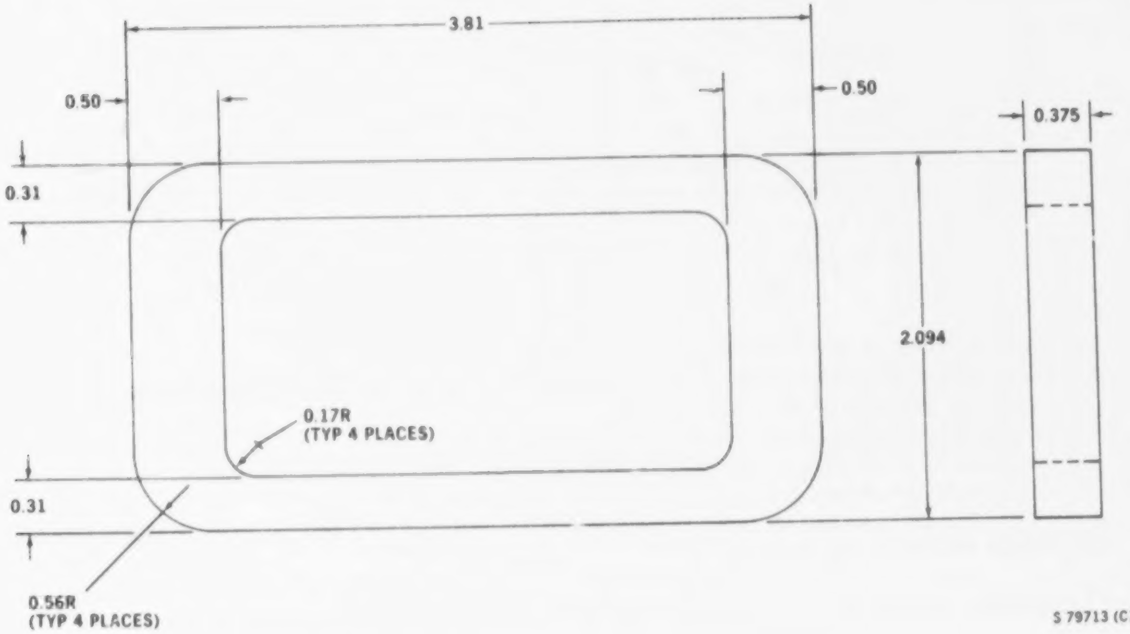
NOTES:

1. MAKE FROM SHEET RUBBER, MIL-R-6855, CLASS 2, TYPE A, GRADE 40, 0.062 INCH THICK, NSN 9320-00-057-9820.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GRAY INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: $\underbrace{\text{P/N 70216-02401-107}}_{\text{PART NUMBER}}$ $\underbrace{\text{3Q}}_{\text{THIRD QUARTER}}\underbrace{\text{86}}_{\text{1986}}$

PART NUMBER: 70500-02058-151 DUCT INSTALLATION SEAL.

FIGURE H-46. DUCT INSTALLATION SEAL


3.81
0.50
0.50
0.375
0.31
2.094
0.17R
(TYP 4 PLACES)
0.31
0.56R
(TYP 4 PLACES)
S 79713 (C17)

NOMENCLATURE	SIKORSKY PART NUMBER
DUCT INSTALLATION SEAL	70500-02058-161

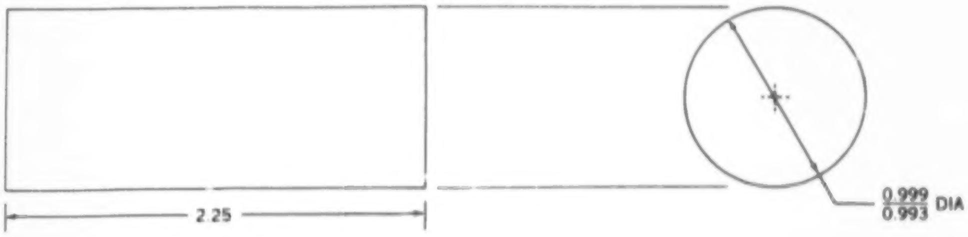
NOTES:

1. MAKE FROM SHEET RUBBER, MIL-R-6130, TYPE 2, GRADE A, SOFT, 0.375 INCH THICK, NSN 5330-00-232-2420.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GRAY INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER
1986
THIRD QUARTER

PART NUMBER: 70500-02058-161 DUCT INSTALLATION SEAL.

FIGURE H-47. DUCT INSTALLATION SEAL

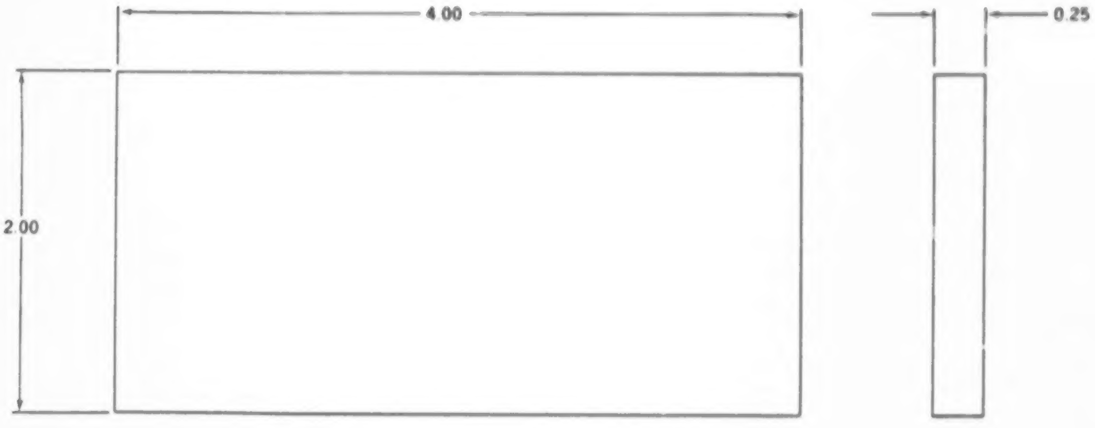


S 79716 (C17)

NOTES:
1. MAKE FROM AN16-33 BOLT, NSN 5306-00-145-6790.
2. CUT THREADED PORTION AND HEAD FROM BOLT TO REQUIRED SIZE, AS SHOWN.
3. ALL DIMENSIONS ARE IN INCHES.
4. BREAK ALL SHARP EDGES TO 0.005 - 0.015 RADIUS.
5. CADMIUM-PLATE ENDS, AS REQUIRED, PER QQ-P-416, TYPE II, CLASS 3.
6. IDENTIFY PARTS PER MIL-STD-130.
7. FOR ALTERNATE MATERIAL, USE NONCORROSION RESISTANT STEEL ROD, 1-INCH DIAMETER, MIL-S-5626, NSN 9510-00-596-3933.

PART NUMBER: 1420-BH-001, SPINDLE BONDED WASHER REPAIR LOCATING TOOL.

FIGURE H-48. LOCATING TOOL

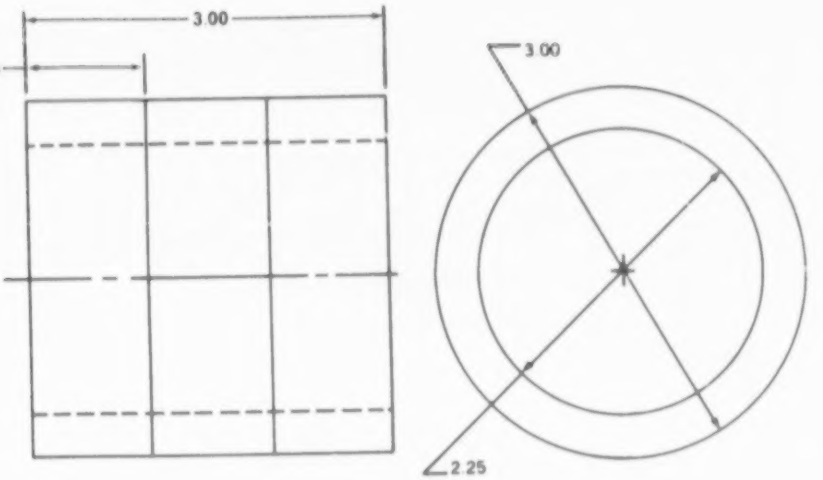


S 79717 (C17)

NOTES:
1. MAKE FROM 0.25 THICK STEEL STOCK, MIL-S-5626, NSN 9510-00-596-2176.
2. ALL DIMENSIONS ARE IN INCHES.
3. BREAK ALL SHARP EDGES TO 0.005 - 0.015 RADIUS.
4. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 1420-BH-002, SPINDLE BONDED WASHER REPAIR COMPRESSION PLATE.

FIGURE H-49. SIZING BLOCK

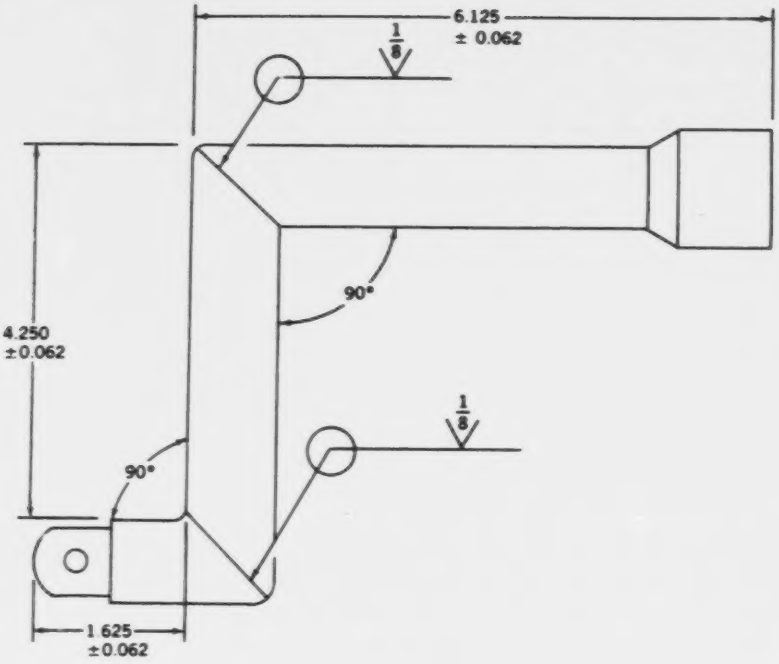


S 79719 (C17)

NOTES:
1. MAKE FROM 1-INCH THICK PHENOLIC SHEET, MIL-P-15035, NSN 9330-00-585-8678.
2. CUT THREE RINGS FROM PHENOLIC SHEET AS SHOWN IN FIGURE.
3. ALL DIMENSIONS ARE IN INCHES.
4. SURFACE FINISH $125\sqrt{}$ ALL MACHINED SURFACES.
5. BREAK ALL SHARP EDGES TO 0.005 - 0.015 RADIUS.
6. ASSEMBLE AND BOND RINGS, AS SHOWN, USING GENERAL PURPOSE CEMENT EC847, NSN 8040-00-262-9011.
7. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 1420-BH-007, MAIN TRANSMISSION OIL PUMP INSTALLATION TOOL.

FIGURE H-50. OIL PUMP INSTALLATION TOOL



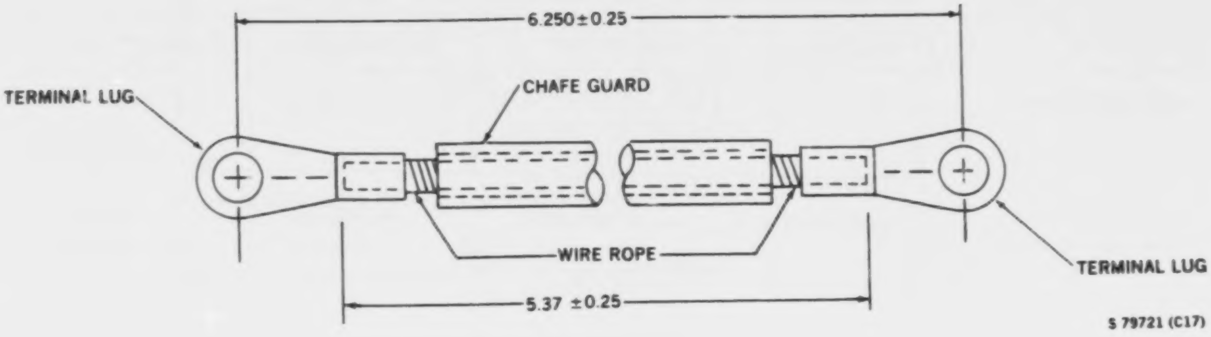
S 79720 (C17)

NOTES:

1. MAKE FROM 16 INCH LONG, 3/4-INCH DRIVE EXTENSION, GGG-W-641, TYPE IV, CLASS 4, STYLE A, NSN 5120-00-227-8079.
2. CUT DRIVE EXTENSION AND WELD AS SHOWN, PER INSTRUCTIONS IN TM 55-1500-204-25/1.
3. ALL DIMENSIONS ARE IN INCHES.
4. GRIND WELDS TO A SMOOTH CONTOUR.
5. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 1420-BH-008, MAIN TRANSMISSION MOUNTING BOLT ADAPTER.

FIGURE H-51. MOUNTING BOLT ADAPTER

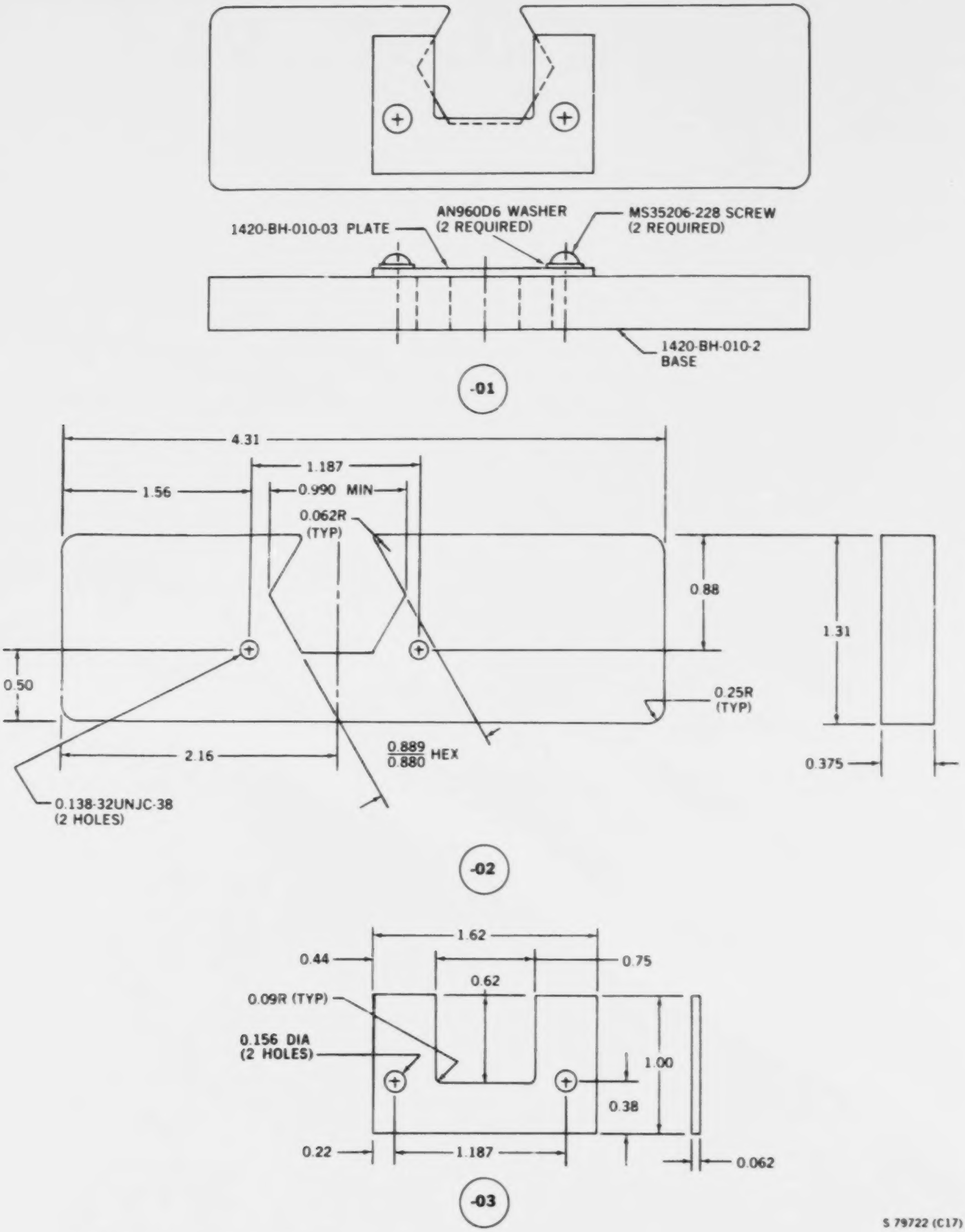

6.250±0.25
TERMINAL LUG
CHAFE GUARD
WIRE ROPE
TERMINAL LUG
5.37 ±0.25
S 79721 (C17)

NOTES:
1. MAKE FROM:
   A. WIRE ROPE, FLEXIBLE, MIL-W-83420, TYPE I, COMPOSITION A OR B, NSN 4010-01-005-4775.
   B. TERMINAL LUG, MS25036-113, NSN 5940-00-113-8183.
   C. CHAFE GUARD (INSULATION SLEEVE) MIL-I-7444, TYPE I, NSN 5970-00-846-3165.
2. ALL DIMENSIONS ARE IN INCHES.
3. CUT WIRE ROPE AND CHAFE GUARD TO REQUIRED LENGTH, AS SHOWN. SLIDE CHAFE GUARD OVER WIRE ROPE AND ASSEMBLE TERMINAL LUGS TO EACH END. CRIMP LUGS TO WIRE ROPE PER MS3316.
4. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 1420-BH-009, CELL PULLER.

FIGURE H-52. CELL PULLER

best copy available


1420-BH-010-03 PLATE
AN960D6 WASHER
(2 REQUIRED)
MS35206-228 SCREW
(2 REQUIRED)
1420-BH-010-2
BASE
-01
4.31
1.187
1.56
0.990 MIN
0.062R
(TYP)
0.88
1.31
0.50
0.25R
(TYP)
2.16
0.889
0.880
HEX
0.375
0.138-32UNJC-38
(2 HOLES)
-02
1.62
0.44
0.75
0.62
0.09R (TYP)
0.156 DIA
(2 HOLES)
1.00
0.38
0.22
1.187
0.062
-03

S 79722 (C17)

FIGURE H-53. FLIGHT CONTROL QUICK DISCONNECT WRENCH (SHEET 1 OF 2)

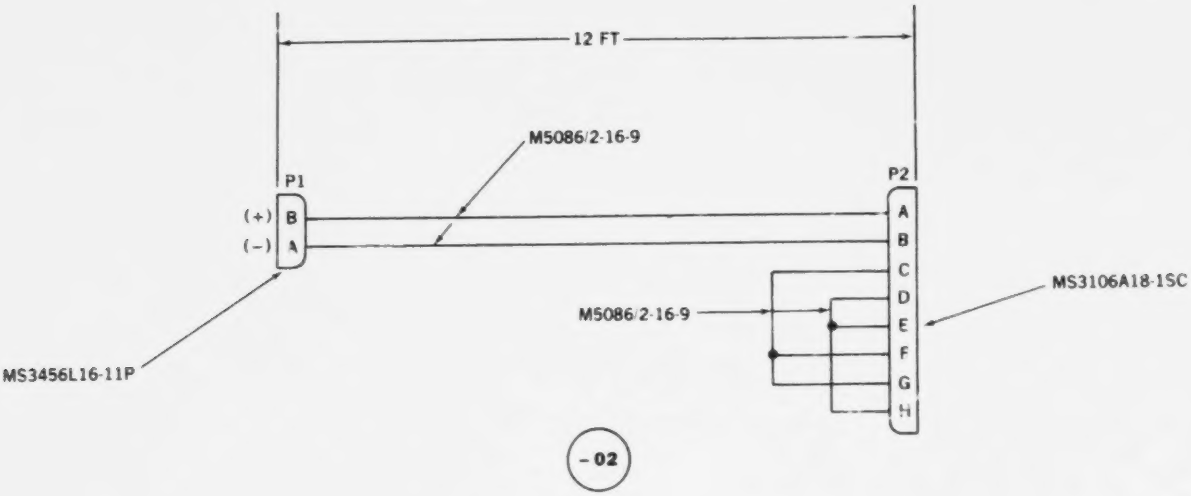
PART NUMBER	DESCRIPTION	MATERIAL	QUANTITY	NSN
1420-BH-010-02	BASE	0.375 6061-T6 AL. ALLOY, QQ-A-250/11	1	9535-01-029-8266
1420-BH-010-03	PLATE	0.062 6061-T6 AL. ALLOY, QQ-A-250/11	1	9535-00-084-4448
AN960D6	WASHER	—	2	5310-00-167-0738
MS35206-228	SCREW	—	2	5305-00-984-4988

NOTES:

1. MAKE 1420-BH-010-02 BASE AS SHOWN IN FIGURE. DRILL AND TAP TWO HOLES, AS SHOWN. USE MATERIAL LISTED IN CHART.
2. MAKE 1420-BH-010-03 PLATE AS SHOWN IN FIGURE. DRILL TWO HOLES AS INDICATED. USE MATERIAL LISTED IN CHART.
3. ALL DIMENSIONS ARE IN INCHES.
4. TOLERANCE: ANGULAR, ±0° 30'.
   LINEAR (EXCEPT HOLES), .XX = ±0.03, .XXX = ±0.010.
5. SURFACE FINISH 125√ ALL MACHINED SURFACES.
6. BREAK SHARP EDGES TO 0.005 - 0.015 RADIUS.
7. ATTACH PLATE TO BASE USING AN960D6 WASHER (2) AND MS35206-228 SCREW (2) TO MAKE 1420-BH-010-01 WRENCH.
8. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 1420-BH-010-01 FLIGHT CONTROL QUICK DISCONNECT WRENCH.

FIGURE H-53. FLIGHT CONTROL QUICK DISCONNECT WRENCH (SHEET 2 OF 2)


12 FT
M5086/2-16-9
P1
P2
(+)
(−)
B
A
A
B
C
D
E
F
G
H
M5086/2-16-9
MS3106A18-1SC
MS3456L16-11P
−02

POWER CABLE ASSEMBLY

S 79723 1 (C17)

CHART A

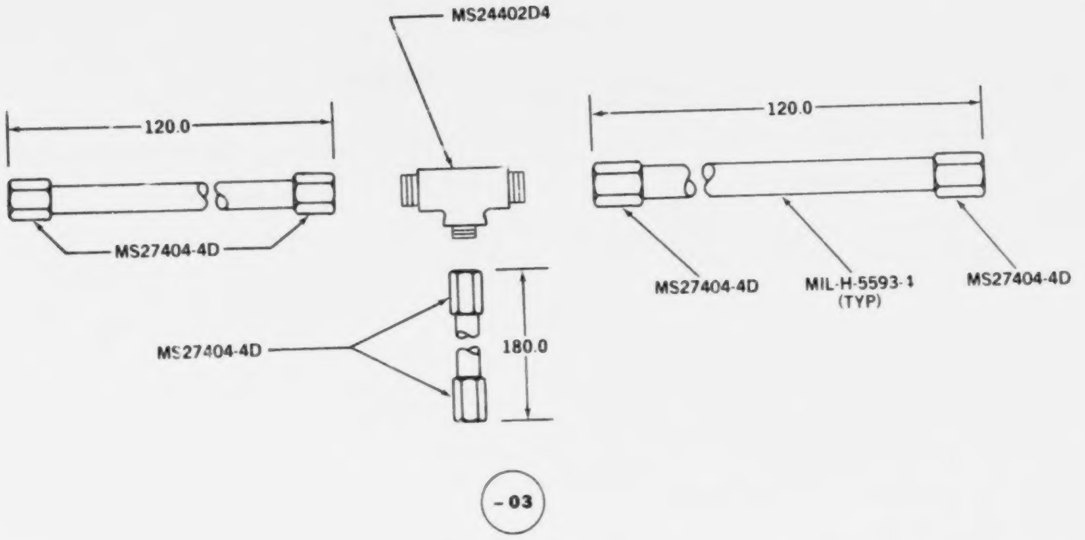
PART NUMBER	DESCRIPTION	QUANTITY	NSN
MS3456L16-11P	CONNECTOR, P1	1	5935-01-PAC-6669
MS3106A18-1SC	CONNECTOR, P2	1	5935-00-284-3967
M5086/2-16-9	WIRE, ELECTRICAL, 16 GAGE	16 FT	6145-00-578-6605

NOTES:

1. MAKE 1420-BH-011-02 POWER CABLE ASSEMBLY PER FIGURE, USING MATERIALS LISTED IN CHART A, OR APPROVED EQUIVALENT.
2. IDENTIFY P1 AND P2 CONNECTORS PER FIGURE AND MIL-STD-130.

PART NUMBER: 1420-BH-011-02 POWER CABLE ASSEMBLY, PITOT-STATIC TEST SET.

FIGURE H-54. PITOT-STATIC TEST SET (SHEET 1 OF 3)


MS24402D4
120.0
120.0
MS27404-4D
MS27404-4D
MIL-H-5593-1
(TYP)
MS27404-4D
MS27404-4D
180.0
-03

TEE AIR HOSE ASSEMBLY (AFCS)

S 79723.2 (C17)

CHART B

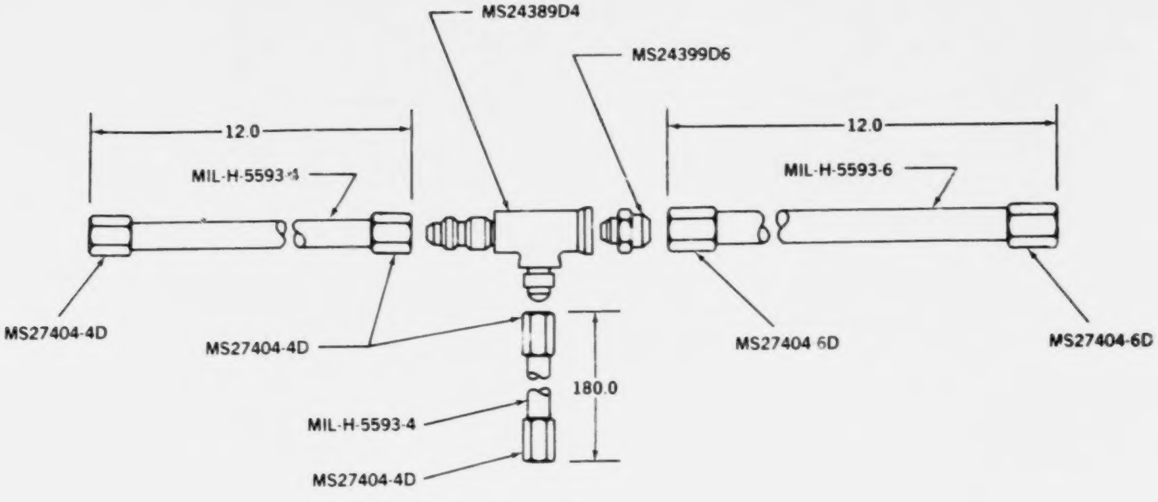
PART NUMBER	DESCRIPTION	QUANTITY	NSN
MS24402D4	TEE, TUBE, 1/4-INCH TUBE OD	1	4730-00-722-1207
MS27404-4D	ADAPTER, 1/4-INCH TUBE OD	6	4730-00-497-4281
MIL-H-5593-4	HOSE, FLEXIBLE, 1/4-INCH ID	35 FT	4720-00-540-1962

NOTES:

1. MAKE 1420-BH-011-03 TEE AIR HOSE ASSEMBLY (AFCS) PER FIGURE, USING MATERIALS LISTED IN CHART B, OR APPROVED EQUIVALENT.
2. IDENTIFY ASSEMBLY WITH PART NUMBER AND NOMENCLATURE, 1420-BH-011-03, TEE AIR HOSE ASSEMBLY (AFCS), PER MIL-STD-130.
3. CAP ENDS OF HOSE WHEN NOT IN USE.

PART NUMBER: 1420-BH-011-03 TEE AIR HOSE ASSEMBLY (AFCS), PITOT-STATIC TEST SET.

FIGURE H-54. PITOT-STATIC TEST SET (SHEET 2 OF 3)


MS24389D4
MS24399D6
12.0
12.0
MIL-H-5593-4
MIL-H-5593-6
MS27404-4D
MS27404-4D
MS27404-6D
MS27404-6D
180.0
MIL-H-5593-4
MS27404-4D

-04

TEE AIR HOSE ASSEMBLY (PITOT-STATIC/IFF)

S 79723 3 (C17)

CHART C

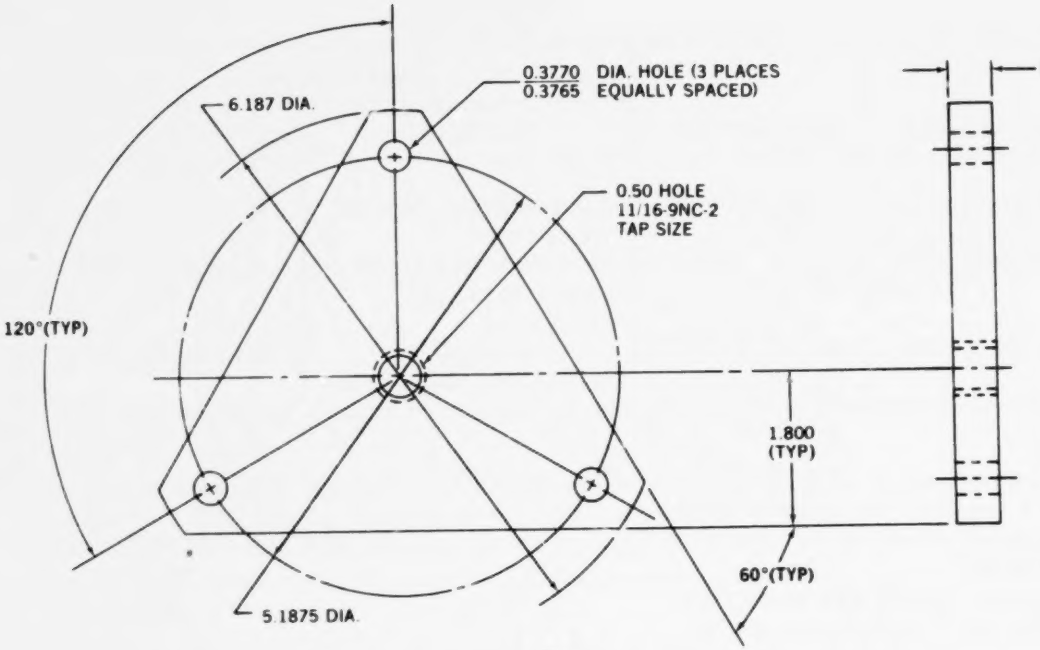
PART NUMBER	DESCRIPTION	QUANTITY	NSN
MS24389D4	TEE, TUBE, 1/4-INCH TUBE OD	1	4730-00-804-8683
MS24399D6	REDUCER, 3/8-INCH TUBE OD	1	4730-00-752-9336
MS27404-4D	ADAPTER, 1/4-INCH TUBE OD	4	4730-00-497-4281
MS27404-6D	ADAPTER, 3/8-INCH TUBE OD	2	4730-00-278-5686
MIL-H-5593-4	HOSE, FLEXIBLE, 1/4-INCH ID	16 FT	4720-00-540-1962
MIL-H-5593-6	HOSE, FLEXIBLE, 3/8-INCH ID	1 FT	4720-00-720-1096

NOTES:

1. MAKE 1420-BH-011-04 TEE AIR HOSE ASSEMBLY (PITOT-STATIC/IFF) PER FIGURE, USING MATERIAL LISTED IN CHART C, OR APPROVED EQUIVALENT.
2. IDENTIFY ASSEMBLY WITH PART NUMBER AND NOMENCLATURE, 1420-BH-011-04, TEE AIR HOSE ASSEMBLY (PITOT-STATIC/IFF), PER MIL-STD-130.
3. ASSEMBLIES 1420-BH-011-02, 1420-BH-011-03, AND 1420-BH-011-04, MAKE UP 1420-BH-011-01 PITOT-STATIC TEST SET.
4. CAP ENDS OF HOSE WHEN NOT IN USE.

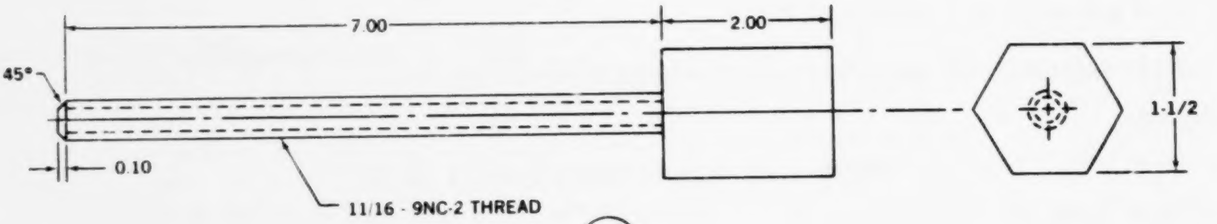
PART NUMBER: 1420-BH-011-04 TEE AIR HOSE ASSEMBLY (PITOT-STATIC/IFF), PITOT-STATIC TEST SET.

FIGURE H-54. PITOT-STATIC TEST SET (SHEET 3 OF 3)


0.3770 DIA. HOLE (3 PLACES
0.3765 EQUALLY SPACED)
6.187 DIA.
0.50
0.50 HOLE
11/16-9NC-2
TAP SIZE
120°(TYP)
1.800
(TYP)
60°(TYP)
5.1875 DIA.

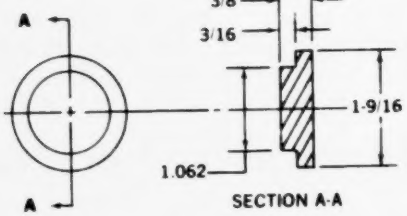
-02

BASEPLATE


7.00
2.00
45°
1-1/2
0.10
11/16 - 9NC-2 THREAD

-03

JACKSCREW


3/8
3/16
A
A
1-9/16
1.062
SECTION A-A

-04

PLUG

S 79724 (C17)

FIGURE H-55. FLANGE PULLER (SHEET 1 OF 2)

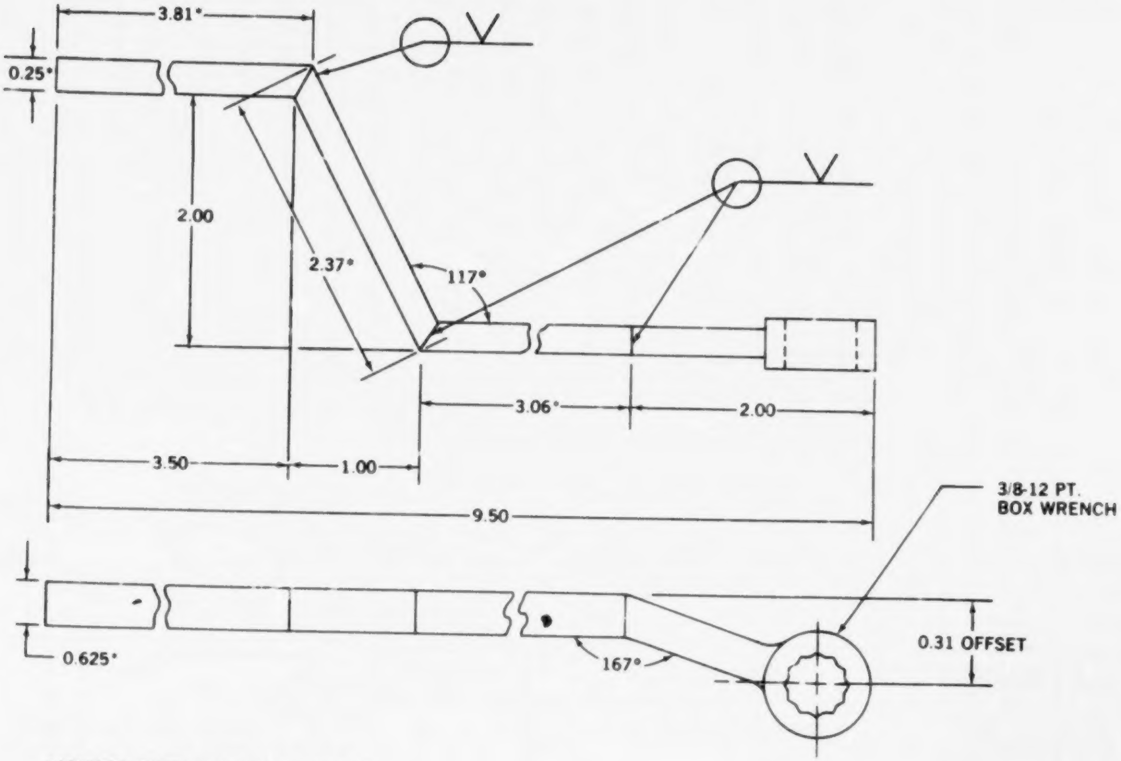
		MAKE FROM	
PART NUMBER	DESCRIPTION	MATERIAL	NSN
1420-BH-012-02	BASE PLATE	0.50 4130 STEEL PLATE, MIL-S-18729	9515-00-294-9916
1420-BH-012-03	JACK SCREW	1-1/2 INCH HEXAGON BAR, 4130 STEEL, MIL-S-6758	9510-00-528-5000
1420-BH-012-04	PLUG	1-9/16 DIA ROD, 4130 STEEL, MIL-S-6758	9510-00-993-5836

NOTES:

1. MAKE 1420-BH-012-02 BASE PLATE, 1420-BH-012-03 JACK SCREW AND 1420-BH-012-04 PLUG PER FIGURE, USING MATERIALS LISTED IN CHART. DRILL AND TAP BASE PLATE AND THREAD JACK SCREW TO 11/16-9NC-2 THREAD SIZE PER INSTRUCTIONS IN FIGURE.
2. ALL DIMENSIONS ARE IN INCHES.
3. TOLERANCE: ANGULAR, ±0° 30'.
   LINEAR, .XX = ±0.03, .XXX = ±0.010, X/X = ±1/32.
4. SURFACE FINISH $\overset{125}{\surd}$ ALL MACHINED SURFACES.
5. BREAK SHARP EDGES TO 0.005 - 0.015 RADIUS.
6. ASSEMBLE 1420-BH-012-02, 1420-BH-012-03, AND 1420-BH-012-04 TO MAKE 1420-BH-012-01 FLANGE PULLER.
7. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 1420-BH-012-01 TAIL GEAR BOX FLANGE PULLER.

FIGURE H-55. FLANGE PULLER (SHEET 2 OF 2)



*APPROX. DIMENSIONS (SEE NOTE 2)

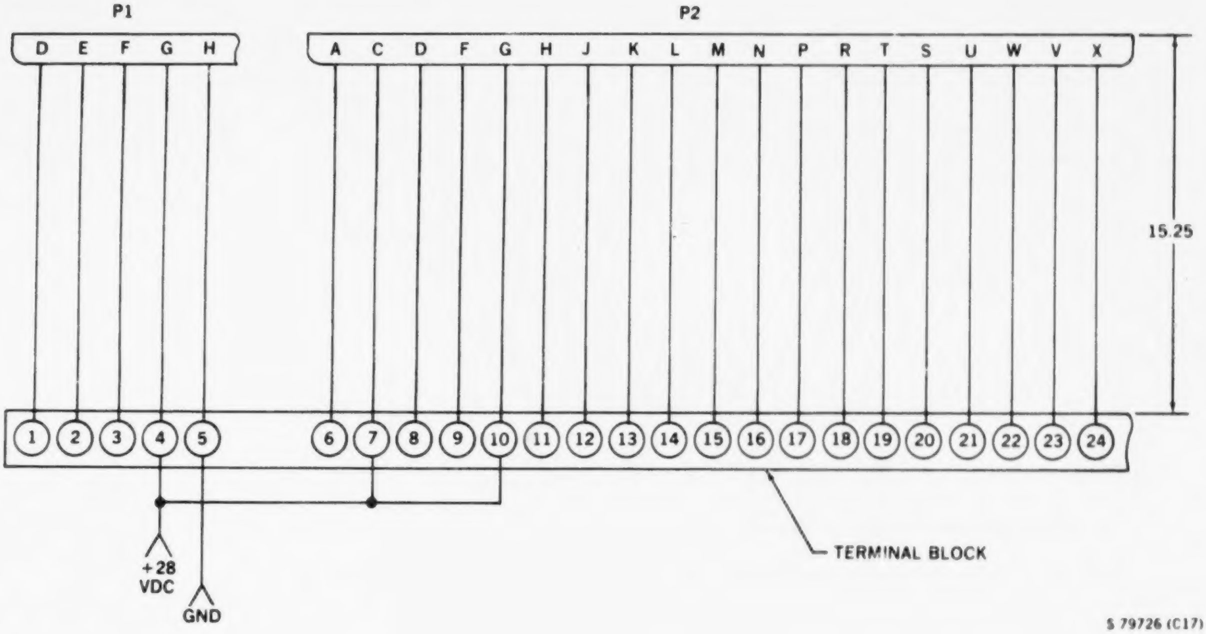
S 79725 (C17)

NOTES:

1. USE HEAD OF 3/8-INCH BOX WRENCH, 12-POINT, PER GGG-W-1437, TYPE III, OR EQUIVALENT, NSN 5120-00-935-7362. CUT WRENCH AS SHOWN IN FIGURE AND STRAIGHTEN ANGULAR OFFSET.
2. MAKE HANDLE FROM 4130 STEEL BAR STOCK, MIL-S-18729, NSN 9510-01-032-3708. WIDTH AND THICKNESS DIMENSIONS OF BAR STOCK, AS SHOWN IN FIGURE, ARE APPROXIMATE. EXACT DIMENSIONS WILL DEPEND UPON CROSS-SECTIONAL DIMENSIONS OF MATING PART OF BOX END WRENCH USED. MAINTAIN DIMENSIONS NOT MARKED BY ASTERISK (*).
3. TOLERANCE: ±0.05 FOR FABRICATED HANDLE.
4. CUT BAR STOCK TO REQUIRED SIZES AND WELD PARTS PER INFORMATION IN FIGURE.
5. GRIND WELDS TO A SMOOTH CONTOUR.
6. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 1420-BH-013, WRENCH FOR TAIL ROTOR PIVOT BEARING REPLACEMENT.

FIGURE H-56. PIVOT BEARING REPLACEMENT WRENCH


P1
D
E
F
G
H
P2
A
C
D
F
G
H
J
K
L
M
N
P
R
T
S
U
W
V
X
15.25
1
2
3
4
5
6
7
8
9
10
11
12
13
14
15
16
17
18
19
20
21
22
23
24
TERMINAL BLOCK
+28
VDC
GND
S 79726 (C17)

PART NUMBER	DESCRIPTION	QUANTITY	NSN
MS27212-1-28 OR EQUIVALENT	TERMINAL BLOCK	1	5440-00-132-2761 (10 PT) 5440-00-950-1610 (20 PT)
MS3472W12-8P	CONNECTOR, P1	1	5935-01-027-4355
MS3472W16-26P	CONNECTOR, P2	1	5935-00-568-3706
M7078/3-20-7 OR EQUIVALENT	ELECTRICAL WIRE, 20-GAGE, MIL-C-7078/3	15 INCH	6145-01-028-3813

NOTES:

1. MAKE SWITCH PANEL TEST HARNESS AS SHOWN IN FIGURE, USING MATERIALS LISTED IN CHART, SELECT TERMINAL BLOCK, AS REQUIRED.
2. DIMENSIONS ARE IN INCHES.
3. TIE WIRES TOGETHER OR COVER WITH APPROVED INSULATION TUBING.
4. IDENTIFY TEST HARNESS AND CONNECTORS P1 AND P2 PER FIGURE AND MIL-STD-130.

PART NUMBER: 1730-BH-001-01, MISCELLANEOUS SWITCH PANEL TEST HARNESS - GROUND SUPPORT EQUIPMENT.

FIGURE H-57. SWITCH PANEL TEST HARNESS

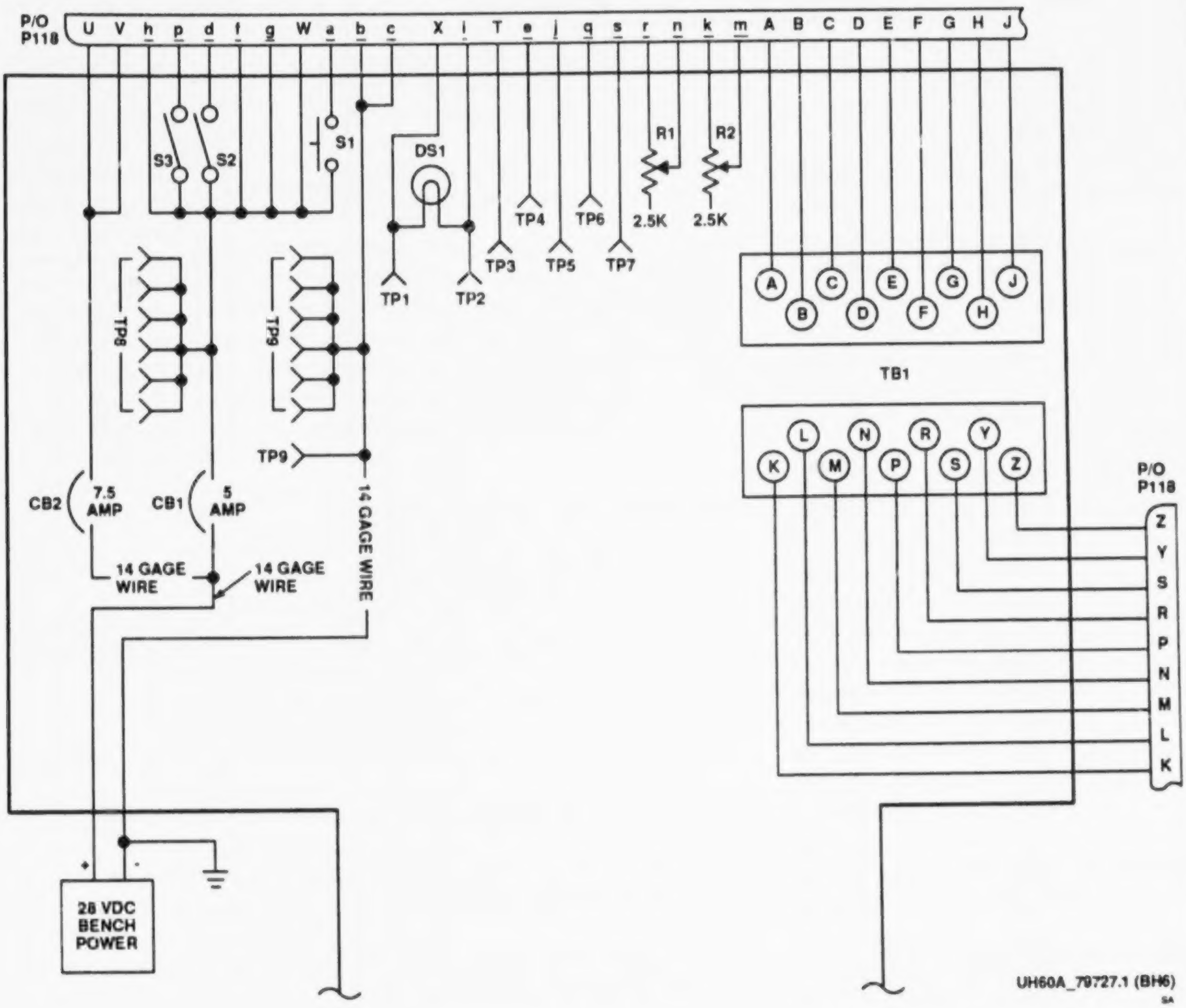

P/O
P118
U V h p d f g W a b c X i T e j q s r n k m A B C D E F G H J
S3
S2
S1
DS1
R1
R2
2.5K
2.5K
TP4
TP6
TP3
TP5
TP7
TP1
TP2
TP8
TP9
TP9
A B C D E F G H J
TB1
L N R Y
K M P S Z
CB2
7.5
AMP
CB1
5
AMP
14 GAGE WIRE
14 GAGE WIRE
14 GAGE WIRE
P/O
P118
Z Y S R P N M L K
+
-
28 VDC
BENCH
POWER
UH60A_79727.1 (BH6)
SA

FIGURE H-58. TEST ADAPTER (SHEET 1 OF 3)

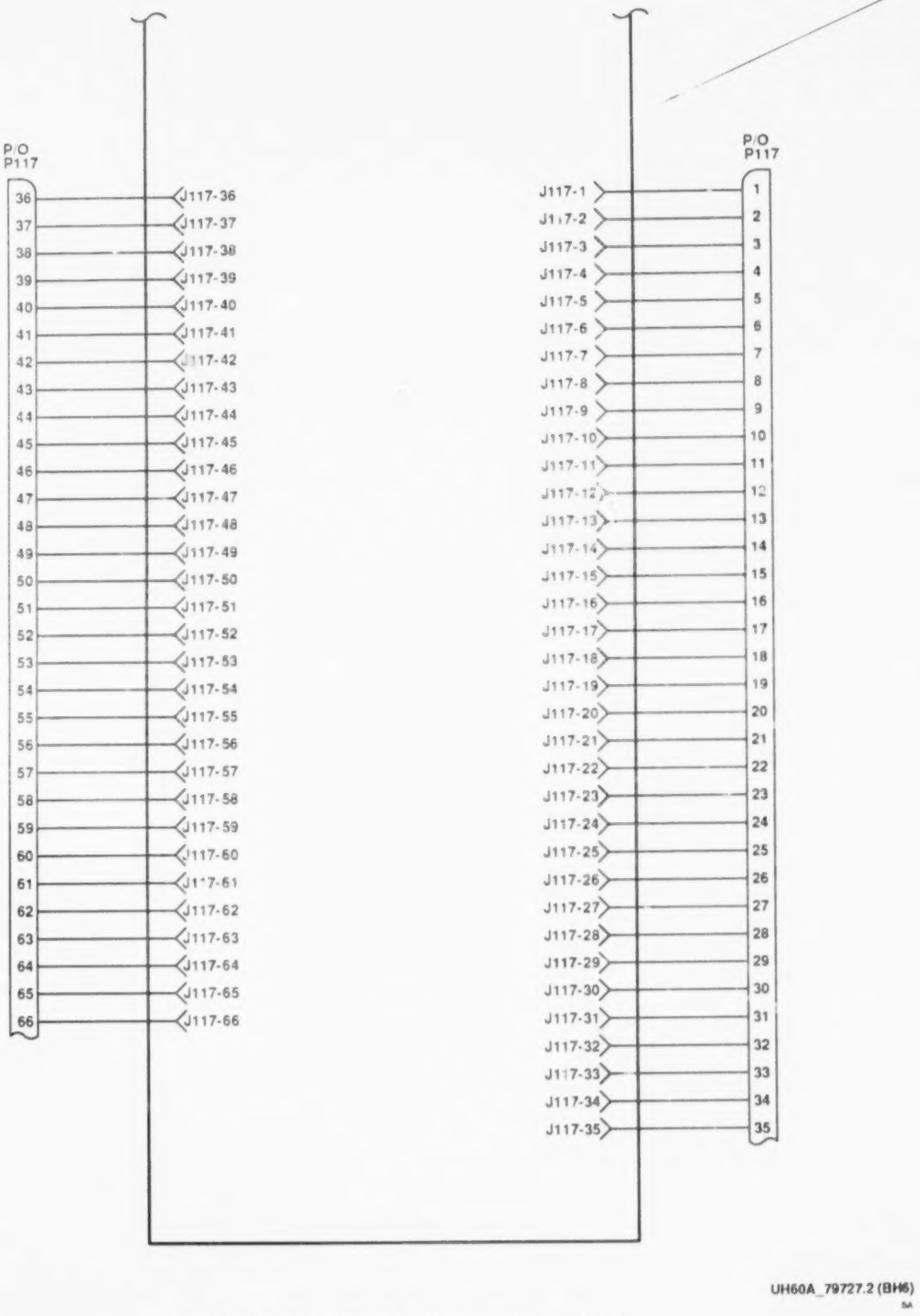

P/O
P117
36
37
38
39
40
41
42
43
44
45
46
47
48
49
50
51
52
53
54
55
56
57
58
59
60
61
62
63
64
65
66
J117-36
J117-37
J117-38
J117-39
J117-40
J117-41
J117-42
J117-43
J117-44
J117-45
J117-46
J117-47
J117-48
J117-49
J117-50
J117-51
J117-52
J117-53
J117-54
J117-55
J117-56
J117-57
J117-58
J117-59
J117-60
J117-61
J117-62
J117-63
J117-64
J117-65
J117-66
J117-1
J117-2
J117-3
J117-4
J117-5
J117-6
J117-7
J117-8
J117-9
J117-10
J117-11
J117-12
J117-13
J117-14
J117-15
J117-16
J117-17
J117-18
J117-19
J117-20
J117-21
J117-22
J117-23
J117-24
J117-25
J117-26
J117-27
J117-28
J117-29
J117-30
J117-31
J117-32
J117-33
J117-34
J117-35
P/O
P117
1
2
3
4
5
6
7
8
9
10
11
12
13
14
15
16
17
18
19
20
21
22
23
24
25
26
27
28
29
30
31
32
33
34
35
UH60A_79727.2 (BH6)
SA

FIGURE H-58. TEST ADAPTER (SHEET 2 OF 3)

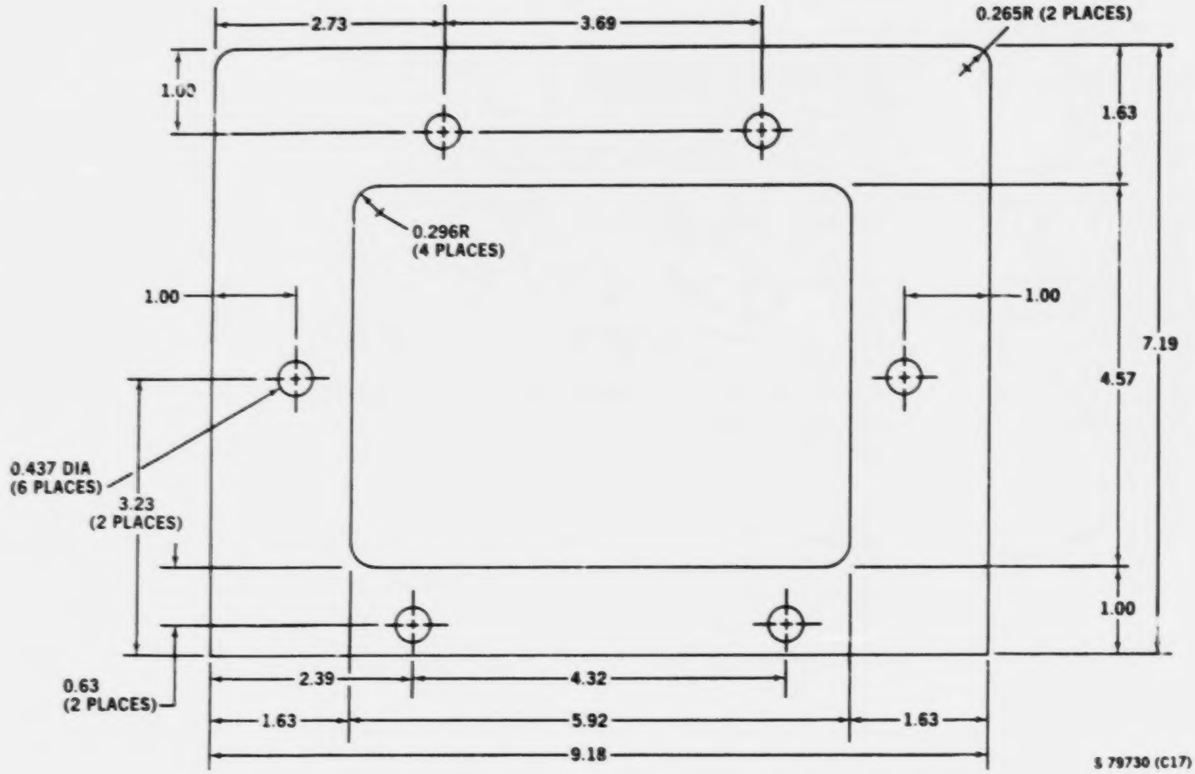
PART NUMBER	DESCRIPTION	QUANTITY	NSN
MS16108-8A	TEST POINT, TP1 THRU TP9	9	5935-00-768-4232
MS24509-5	CIRCUIT BREAKER, CB1	1	5925-00-850-7244
MS24509-7.5	CIRCUIT BREAKER, CB2	1	5925-01-065-2956
MS25089-5CR	SWITCH, S1	1	5930-00-578-2325
MS25098-22	SWITCH, S2 AND S3	2	5930-00-172-2869
MS27212-2-10	TERMINAL BLOCK, TB1	2	5940-00-544-6306
OR EQUIVALENT	–	–	–
MS27467T9F-35S	CONNECTOR P-117	1	5935-00-521-2548
MS3476L20-41S	CONNECTOR P118	1	5935-00-009-3157
M5086/2-14 OR EQUIVALENT	ELECTRICAL WIRE, 14 GAGE PER MIL-W-5086/2	AS REQ'D	6145-00-815-8505
M5086/2-20-9 OR EQUIVALENT	ELECTRICAL WIRE, 20 GAGE PER MIL-W-5068/2	AS REQ'D	6145-00-952-9290
RV4LAYSA252A	RESISTORS R1 AND R2	2	5905-00-539-2567
OR EQUIVALENT	–	–	–
MS25237-327	LAMP	1	6240-00-155-7836
1010J6-100	SLEEVING, TEXTILE, TUBE INSULATION 3/4 ID YELLOW	AS REQ'D	5970-00-687-0298
–	ALUMINUM BOX, 12.0 X 12.0 X 12.0 INCH (NOTE 3)	1	–
M39024/10-02	TEST JACKS - RED	60	5935-00-687-8090
M39024/10-03	TEST JACKS - BLACK	18	5935-00-169-9437
–	–	–	5935-00-762-0312

NOTES:

1. MAKE TEST ADAPTER PER FIGURE USING MATERIALS LISTED IN CHART.
2. TEST POINTS - BLACK: J117-13, J117-14, J117-18, J117-26, J117-29, J117-30, J117-34, J117-42, J117-45, J117-53, J117-61, J117-62, TP8 (6 JACKS). ALL OTHER TEST POINTS ARE RED.
3. BOX CAN BE PURCHASED FROM ZERO MFG. CO. 14501 49TH ST., NORTH CLEARWATER, FLORIDA 33520, OR LOCALLY FABRICATE USING 12x12x12, 050-2024-T3 ALCLAD, QQ-A-250/5, NSN 935-00-084-4450.
4. IDENTIFY PARTS PER MIL-STD-130.
5. USE 20-GAGE WIRE FOR ALL CONNECTIONS EXCEPT WHERE NOTED IN FIGURE.
6. COVER WIRES WITH INSULATION TUBING.

FIGURE H-58. TEST ADAPTER (SHEET 3 OF 3)

FIGURE H-59. DELETED


2.73
3.69
0.265R (2 PLACES)
1.00
1.63
0.296R
(4 PLACES)
1.00
1.00
7.19
4.57
0.437 DIA
(6 PLACES)
3.23
(2 PLACES)
1.00
0.63
(2 PLACES)
2.39
4.32
1.63
5.92
1.63
9.18

S 79730 (C17)

NOMENCLATURE	SIKORSKY PART NUMBER
TRANSMISSION DRIP PAN SEAL	70070-50005-108

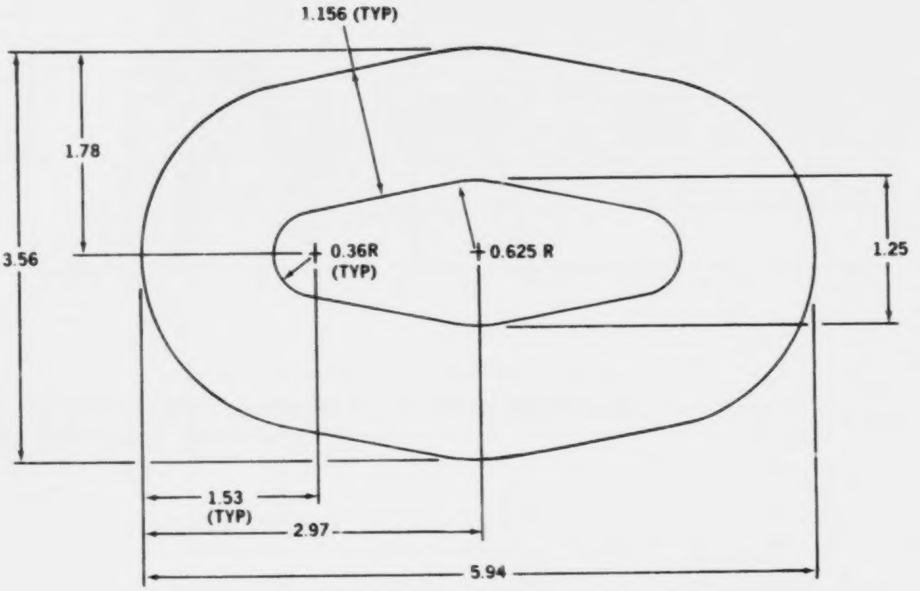
NOTES:

1. MAKE FROM NITRILE RUBBER MIL-R-6855, CLASS 1, GRADE 60, 0.062 INCH THICK, NSN 9320-00-241-9742.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PART PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE YELLOW INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70700-50005-108 TRANSMISSION DRIP PAN SEAL.

FIGURE H-60. TRANSMISSION DRIP PAN SEAL



S 79731 (C17)

NOMENCLATURE	SIKORSKY PART NUMBER
TRANSMISSION DRIP PAN SEAL	70070-50005-113

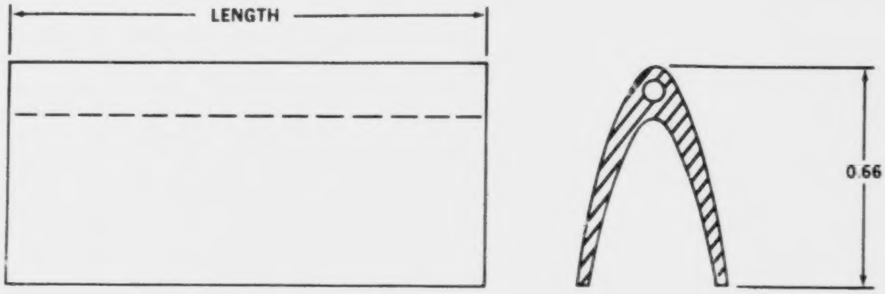
NOTES:

1. MAKE FROM MIL-STD-670, SCE-3L, CD1079 RUBBER, 0.125 INCH THICK, NSN 9320-01-154-2225.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PART PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE YELLOW INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70700-50005-113 TRANSMISSION DRIP PAN SEAL.

FIGURE H-61. TRANSMISSION DRIP PAN SEAL



S 79735 (C17)

DASH NUMBER	LENGTH
-111	3.50
-112	4.50
-113	2.50

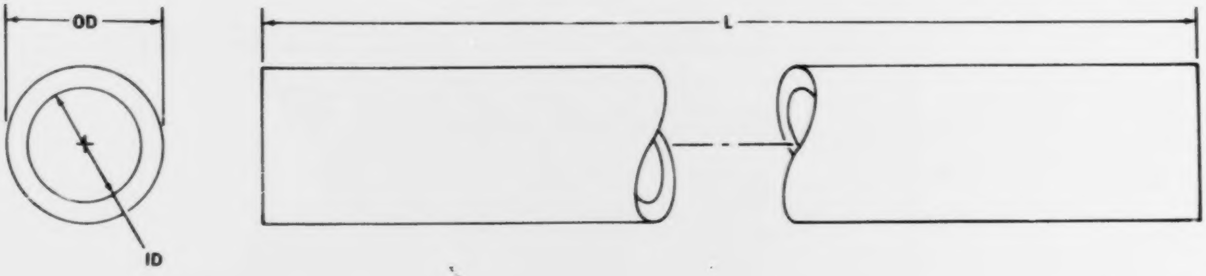
NOTES:

1. MAKE FROM 0.015 THICK EXTRUDED NEOPRENE, CLASS 2, GRADE 60, MIL-R-6855, P/N 11-222106, FSCM 02921.
2. CUT SEAL TO REQUIRED LENGTH AS SHOWN IN CHART.
3. ALL DIMENSIONS ARE IN INCHES.
4. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70205-06052-111, -112, -113 FAIRING INSTALLATION SEAL.

FIGURE H-62. SEAL

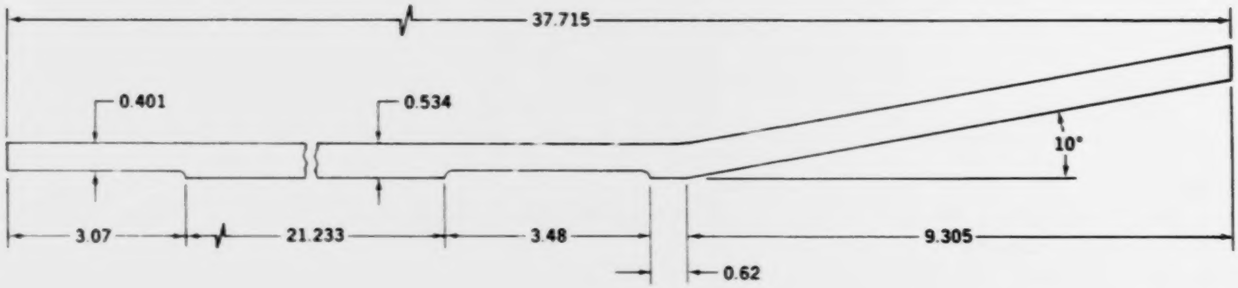


S 79736 (C17)

NOTES:
1. MAKE FROM URETHANE TUBING, (TYGOTHANE) FSCM 34384.
2. ALL DIMENSIONS ARE IN INCHES.
3. CUT ENDS STRAIGHT.
4. DO NOT PAINT.
5. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 70070-50006-107, -108 URETHANE TUBING.

FIGURE H-63. TRANSMISSION DRAIN TUBING



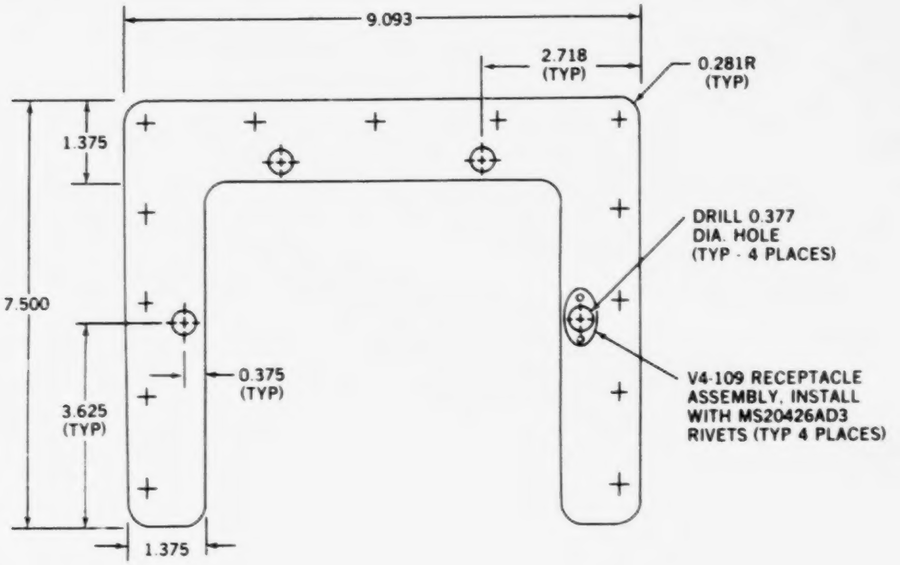
S 79739 (BH1)

NOTES:
1. MAKE FROM 0.063-INCH THICK RUBBER SHEET, MIL-C-3133, GRADE SBE-11L, MIL-STD-670, NSN 9320-00-580-6756.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70219-04704-105 MAIN ROTOR PYLON DOOR CHAFING STRIP.

FIGURE H-64. CHAFING STRIP


9.093
2.718 (TYP)
0.281R (TYP)
1.375
DRILL 0.377 DIA. HOLE (TYP - 4 PLACES)
7.500
0.375 (TYP)
V4-109 RECEPTACLE ASSEMBLY, INSTALL WITH MS20426AD3 RIVETS (TYP 4 PLACES)
3.625 (TYP)
1.375

S 79740 (C17)

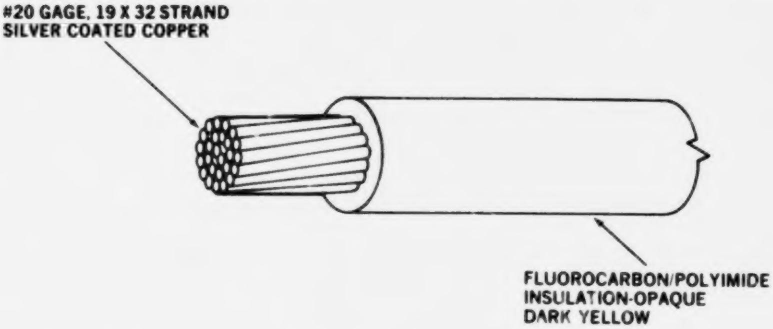
PART NUMBER	DESCRIPTION	QUANTITY	NSN
–	0.050 7075-T6 ALCLAD SHEET, QQ-A-250/13	AR	9535-00-086-9465
V4-109	RECEPTACLE ASSEMBLY	4	5350-00-947-0160
MS20426AD3	RIVET	8	–

NOTES:

1. MAKE STRAP AS SHOWN IN FIGURE, USING MATERIALS LISTED IN CHART.
2. ALL DIMENSIONS ARE IN INCHES.
3. DRILL HOLES (4 PLACES) USING LETTER V DRILL.
4. BREAK SHARP EDGES AND DEBURR ALL HOLES.
5. INSTALL RECEPTACLE ASSEMBLIES PER INSTRUCTIONS IN TM 55-1500-204-25/1.
6. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 70500-02060-124 STRAP, DRIP PAN INSTALLATION.

FIGURE H-65. STRAP

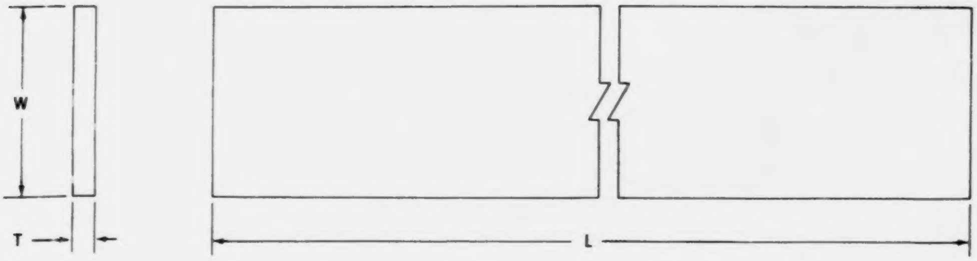

#20 GAGE, 19 X 32 STRAND
SILVER COATED COPPER
FLUOROCARBON/POLYIMIDE
INSULATION-OPAQUE
DARK YELLOW

S 79741 (C17)

NOTES:
1. MAKE FROM M81381/11-20-N, NO. 20 GAGE WIRE, NSN 6145-01-133-2326.
2. CUT WIRE TO REQUIRED SIZE.
3. IDENTIFY PARTS PER MIL-W-5088.

PART NUMBER: 10-615393 ELECTRICAL WIRE, 20 AWG.

FIGURE H-66. ELECTRICAL WIRE



S 79742 (C17)

NOMENCLATURE	T THICKNESS	W WIDTH	L LENGTH	SIKORSKY PART NUMBER
CARGO HOOK ACCESS SEAL	0.093	0.84	19.20	70214-02556-110

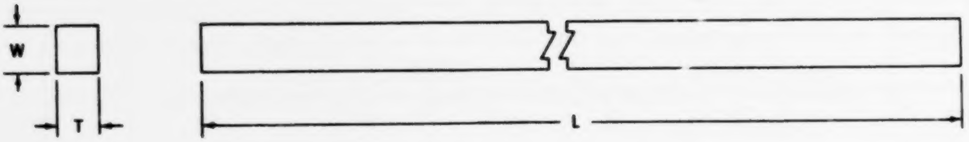
NOTES:

1. MAKE FROM MIL-STD-670, SCE 7L RUBBER, 0.093 INCH THICK, NSN 9320-01-154-2224.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70214-02556-110, CARGO HOOK ACCESS SEAL.

FIGURE H-67. CARGO HOOK ACCESS SEAL



S 79743 (C17)

NOMENCLATURE	T THICKNESS	W WIDTH	L LENGTH	SIKORSKY PART NUMBER
CARGO HOOK ACCESS SEAL	0.188	0.20	19.20	70214-02556-113

NOTES:

1. MAKE FROM MIL-C-3133, SCE 11L RUBBER, 0.188 INCH THICK, NSN 9320-00-282-8284. ALTERNATE, MIL-C-3133, SCE 7L RUBBER, 0.188-INCH THICK, NSN 9320-00-815-9734.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70214-02556-113 CARGO HOOK ACCESS SEAL.

FIGURE H-68. CARGO HOOK ACCESS SEAL

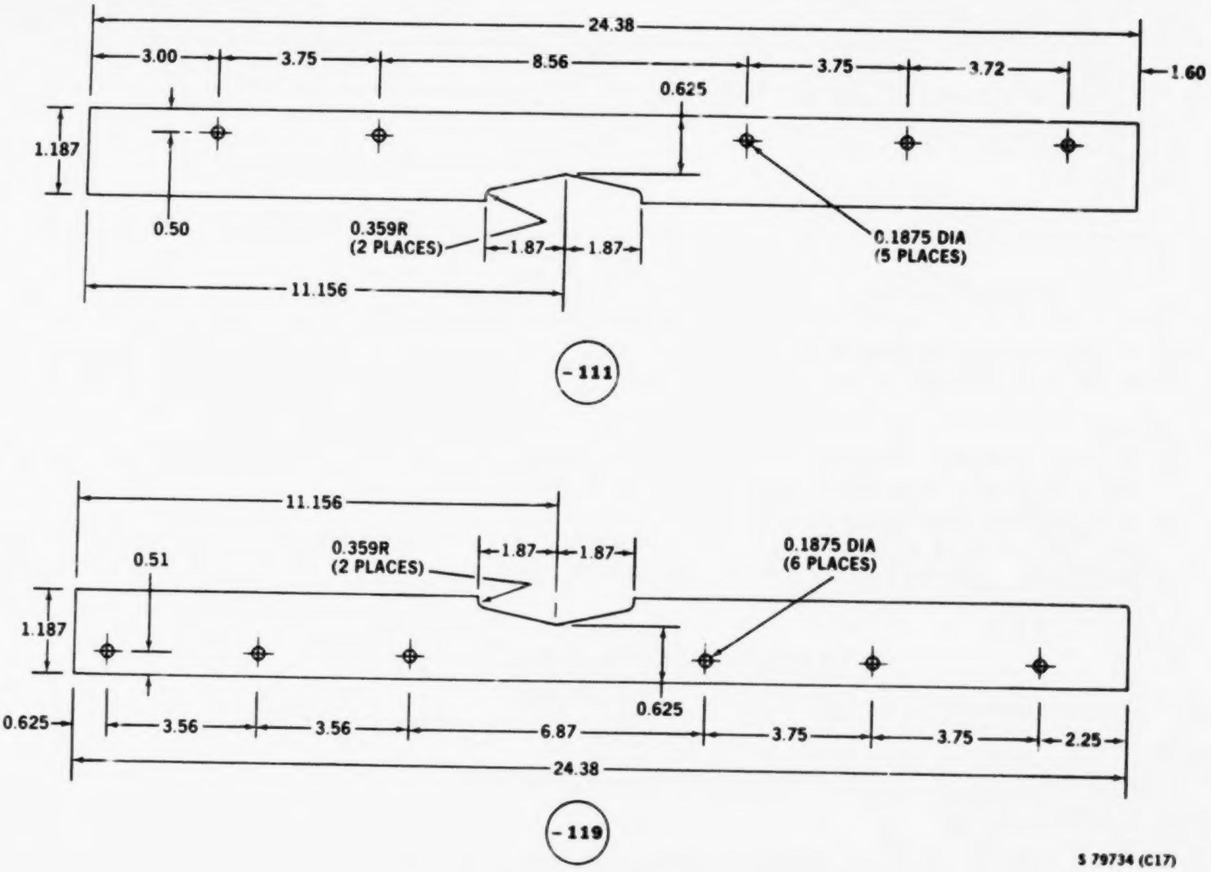

24.38
3.00
3.75
8.56
3.75
3.72
1.60
0.625
1.187
0.50
0.359R
(2 PLACES)
1.87
1.87
0.1875 DIA
(5 PLACES)
11.156
-111
11.156
0.51
0.359R
(2 PLACES)
1.87
1.87
0.1875 DIA
(6 PLACES)
1.187
0.625
0.625
3.56
3.56
6.87
3.75
3.75
2.25
24.38
-119
S 79734 (C17)

FIGURE H-69. TRANSMISSION DRIP PAN SEAL (SHEET 1 OF 2)

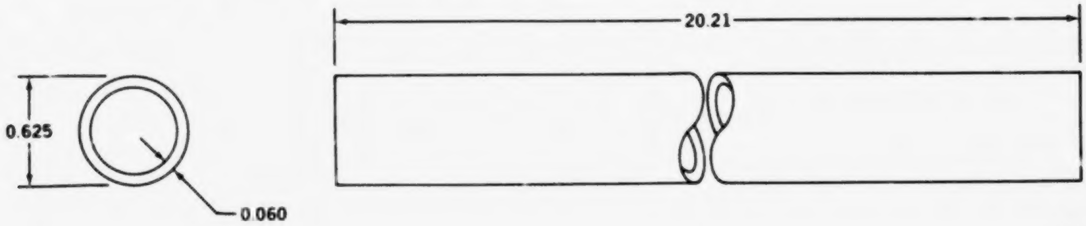
NOMENCLATURE	SIKORSKY PART NUMBER
TRANSMISSION DRIP PAN SEAL	70070-50005-111
	70070-50005-119

NOTES:
1. MAKE FROM MIL-STD-670, SCE-3L, CD1079E RUBBER, 0.312 INCH THICK, NSN 9320-00-181-0016.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PART PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE YELLOW INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70070-50005-111, -119, TRANSMISSION DRIP PAN SEAL.

FIGURE H-69. TRANSMISSION DRIP PAN SEAL (SHEET 2 OF 2)



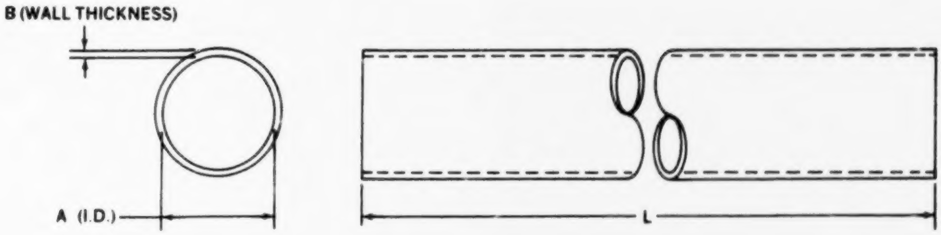
S 79768 (C17)

NOMENCLATURE	SIKORSKY PART NUMBER
CEILING PANEL TUBE	70500-02063-123

NOTES:
1. MAKE FROM LP-390 TYPE 3 POLYETHYLENE TUBING, 0.625 INCH OD, 0.060 INCH WALL, NSN 4710-00-889-4534.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PART PER MIL-STD-130.
4. CUT ENDS STRAIGHT.

PART NUMBER: 70500-02063-123 CEILING PANEL TUBE.

FIGURE H-70. CEILING PANEL TUBE



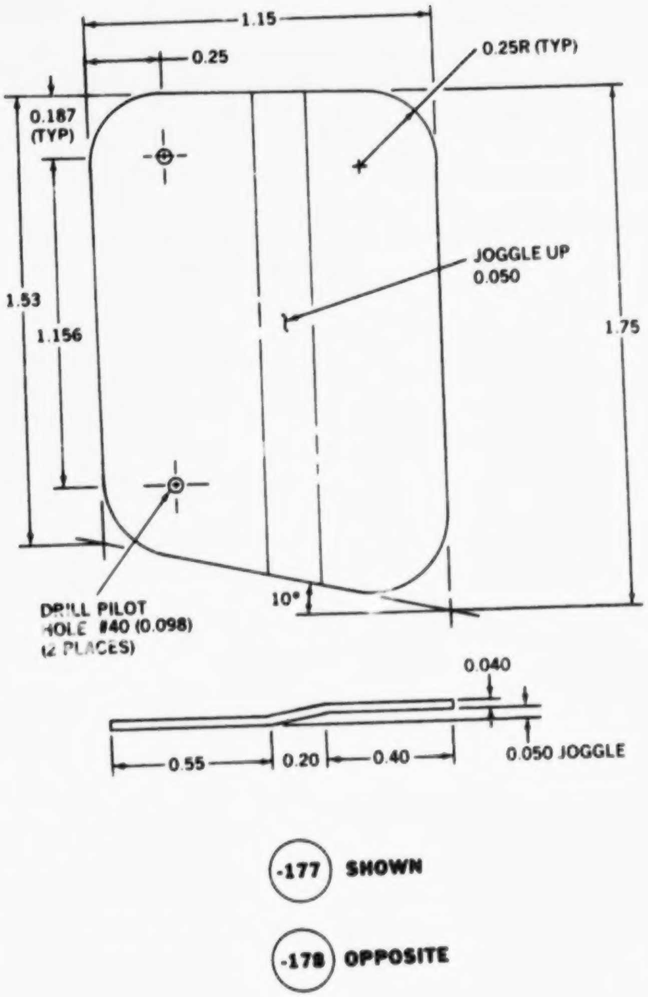
S 79748 (C17)

DASH NO.	A	B	C	MAKE FROM	
				MATERIAL	NSN
-101	0.500	0.032	24.00	TEMFLEX 105C 1/2 INCH CLEAR (75037)	FSCM 75037
-108	0.500	0.020	24.00	KYNAR CONVOLEX TUBING	9330-01-089-0116
-113	0.750	0.020	24.00	KYNAR CONVOLEX TUBING	9330-01-089-0118

NOTES:
1. MAKE TUBE PER MATERIAL AND DIMENSIONS LISTED IN CHART.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 70217-01010-101, -108, -113 NOSE DOOR DRAIN TUBE.

FIGURE H-71. NOSE DOOR DRAIN TUBE


1.15
0.25
0.25R (TYP)
0.187 (TYP)
JOGGLE UP 0.050
1.53
1.156
1.75
DRILL PILOT HOLE #40 (0.098) (2 PLACES)
10°
0.040
0.050 JOGGLE
0.55
0.20
0.40
-177 SHOWN
-178 OPPOSITE

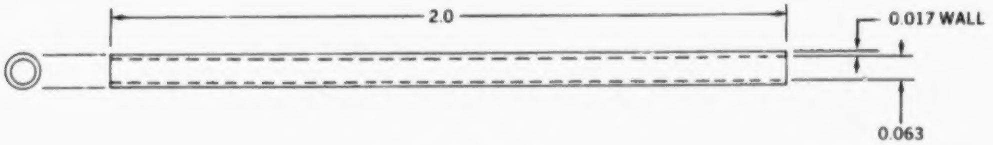
S 79749 (C17)

NOTES:

1. MAKE FROM 0.040 THICK 7075-T6 ALCLAD SHEET, QQ-A-250/13, NSN 9535-00-084-4581.
2. ALL DIMENSIONS ARE IN INCHES.
3. FORM JOGGLE, USING 3/16-INCH RADIUS, PER TM 55-1500-204-25/1.
4. DRILL PILOT HOLES, AS INDICATED, PER TM 55-1500-204-25/1.
5. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 70217-01003-177, -178 CREW DOOR CLIP.

FIGURE H-72. CLIP



S 79750 (C17)

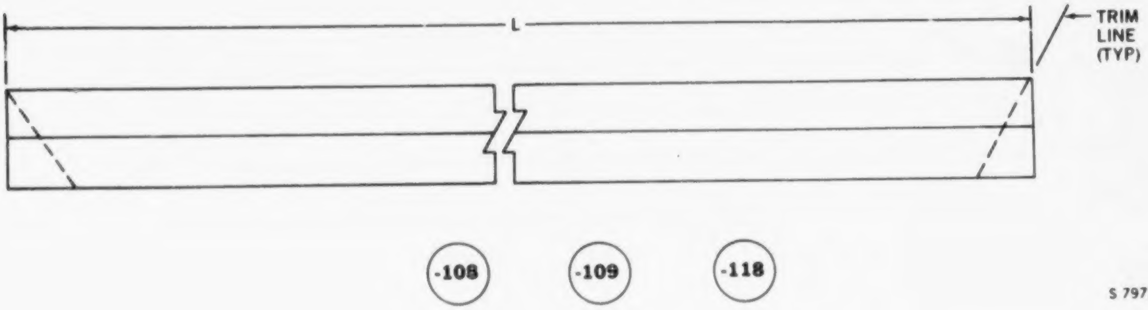
PART NUMBER	MAKE FROM	
	MATERIAL	NSN
10-90604-201	M23053/5-102-0	5970-00-812-2968

NOTES:

1. MAKE SLEEVE PER FIGURE, USING MATERIAL LISTED IN CHART.
2. ALL DIMENSIONS ARE IN INCHES
3. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 10-90604-201 INSULATION SLEEVE.

FIGURE H-73. INSULATION SLEEVE



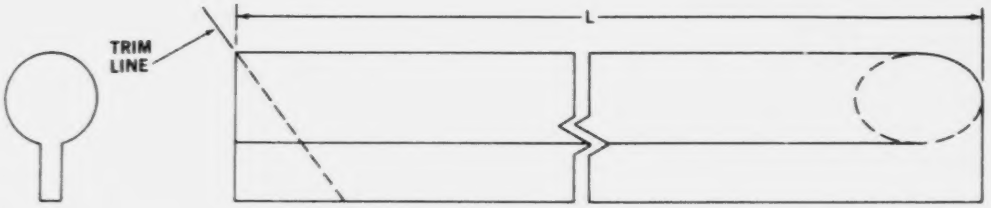
S 79751 (C17)

NOMENCLATURE	L LENGTH	SIKORSKY PART NUMBER
ENGINE INLET FIREWALL SEAL	11.250	70302-10013-108
		70302-10013-109
	8.250	70302-10013-118

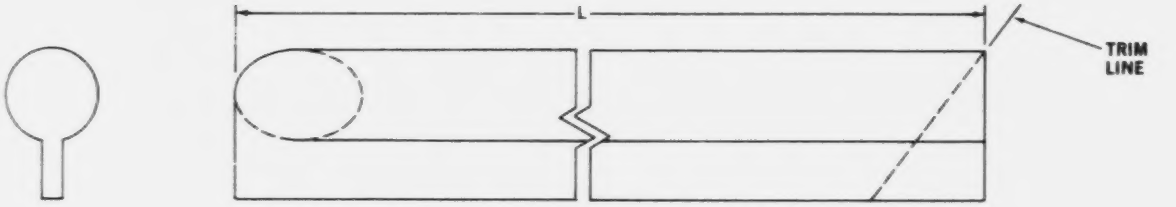
NOTES:
1. MAKE FROM SEAL TAPE, STYLE JM150-13A, NSN 5330-00-849-7083.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-130.
4. TRIM SEAL SECTIONS AS REQUIRED TO BUTT JOIN WITH NO GAP.

PART NUMBER: 70302-10013-108, -109, -118 SEAL.

FIGURE H-74. SEAL, ENGINE INLET FIREWALL



-110



-111

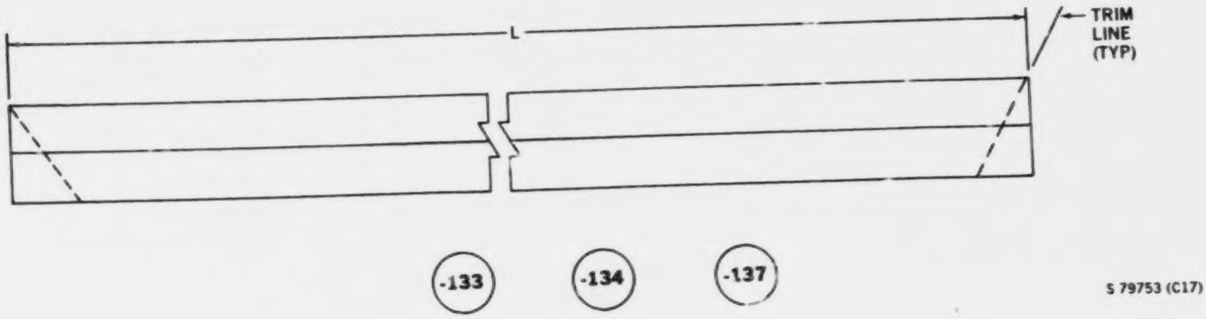
S 79752 (C17)

NOMENCLATURE	L LENGTH	SIKORSKY PART NUMBER
SEAL	6.03	70302-10013-110
		70302-10013-111

NOTES:
1. MAKE FROM SEAL TAPE, STYLE JM150-13A, NSN 5330-00-849-7083.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-130.
4. TRIM SEALS AS REQUIRED TO BUTT JOIN WITH NO GAP.

PART NUMBER: 70302-10013-110, -111 SEAL.

FIGURE H-75. SEAL

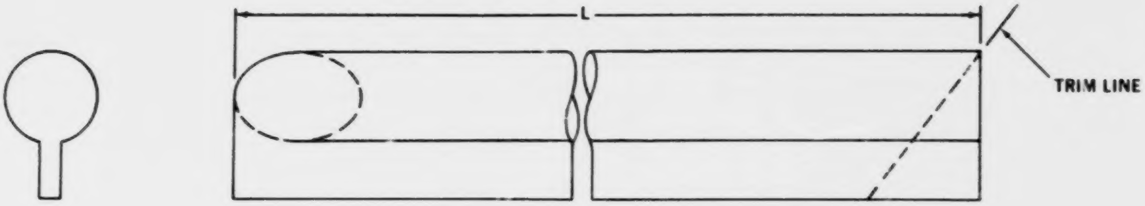


NOMENCLATURE	L LENGTH	SIKORSKY PART NUMBER
ENGINE INLET FIREWALL SEAL	11.250	70302-10013-133
		70302-10013-134
	8.250	70302-10013-137

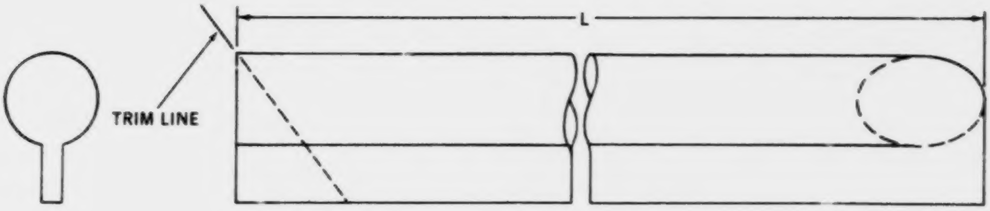
NOTES:
1. MAKE FROM SEAL TAPE, HASKON 8338-3, NSN 5330-01-174-2936.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-130.
4. TRIM SEAL SECTIONS AS REQUIRED TO BUTT JOIN WITH NO GAP.

PART NUMBER: 70302-10013-133, -134, -137 SEAL.

FIGURE H-76. SEAL, ENGINE INLET FIREWALL



-135



-136

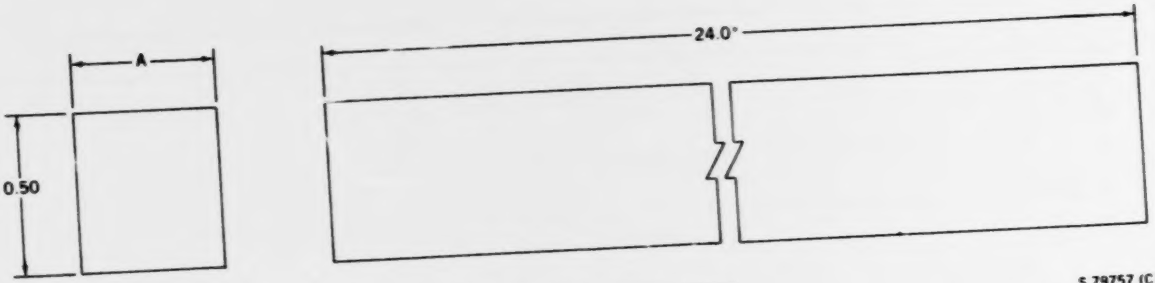
S 79754 (C17)

NOMENCLATURE	L LENGTH	SIKORSKY PART NUMBER
SEAL	6.03	70302-10013-135
		70302-10013-136

NOTES:
1. MAKE FROM SEAL TAPE, HASKON 8338-3, NSN 5330-01-174-2936.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-130.
4. TRIM SEALS AS REQUIRED TO BUTT JOIN WITH NO GAP.

PART NUMBER: 70302-10013-135, -136 SEAL.

FIGURE H-77. SEAL



*OVERSIZE—TRIM TO FIT UPON INSTALLATION

S 79757 (C17)

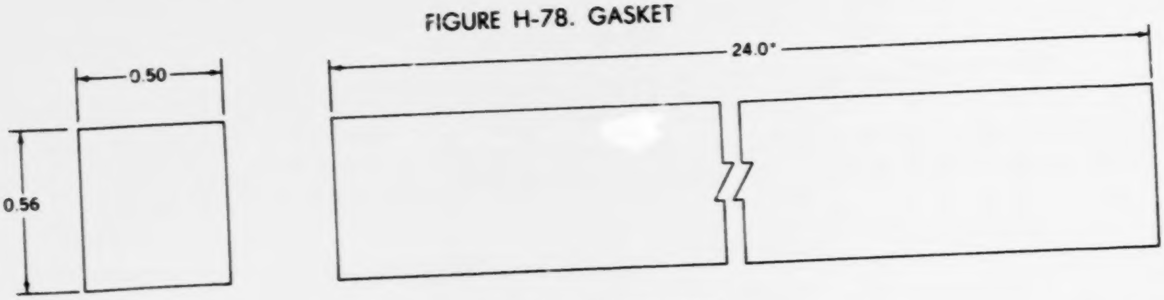
NOTES:

1. MAKE FROM 0.50 THICK RUBBER, CLASS 1, GRADE 40, MIL-R-6855, NSN 9320-00-848-7302.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 — PART NUMBER; 3Q 86 — 3Q: THIRD QUARTER, 86: 1986

PART NUMBER: 70500-03050-114, -154 GASKET, PANEL INSTALLATION, STATION 398 BULKHEAD.

FIGURE H-78. GASKET



*OVERSIZE-TRIM TO FIT UPON INSTALLATION

S 79758 (C17)

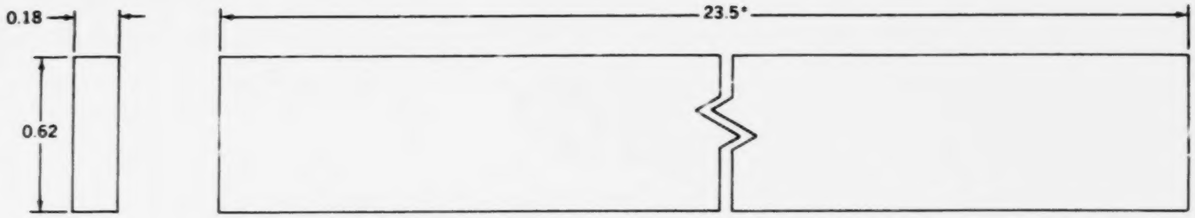
NOTES:

1. MAKE FROM SCE-3LCD RUBBER, MIL-STD-670, NSN 5330-01-100-1889.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 — PART NUMBER; 3Q 86 — 3Q: THIRD QUARTER, 86: 1986

PART NUMBER: 70500-03050-113, -151 GASKET, PANEL INSTALLATION, STATION 398 BULKHEAD.

FIGURE H-79. GASKET



*OVERSIZE-TRIM TO FIT UPON INSTALLATION

S 79759 (C17)

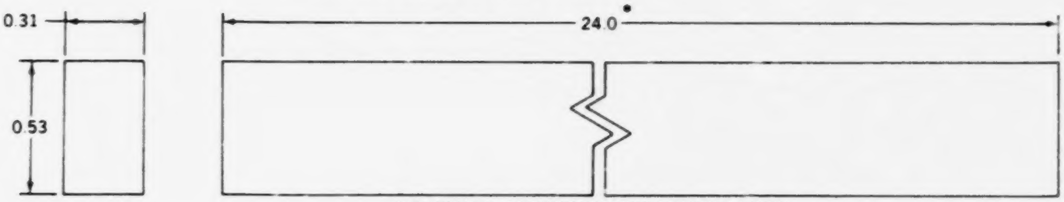
NOTES:

1. MAKE FROM SCE-3LCD RUBBER, MIL-STD-670, NSN 5330-01-100-1888.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70500-03050-115 STATION 398 BULKHEAD PANEL INSTALLATION GASKET.

FIGURE H-80. GASKET



* OVERSIZE - TRIM TO FIT UPON INSTALLATION

S 79760 (C17)

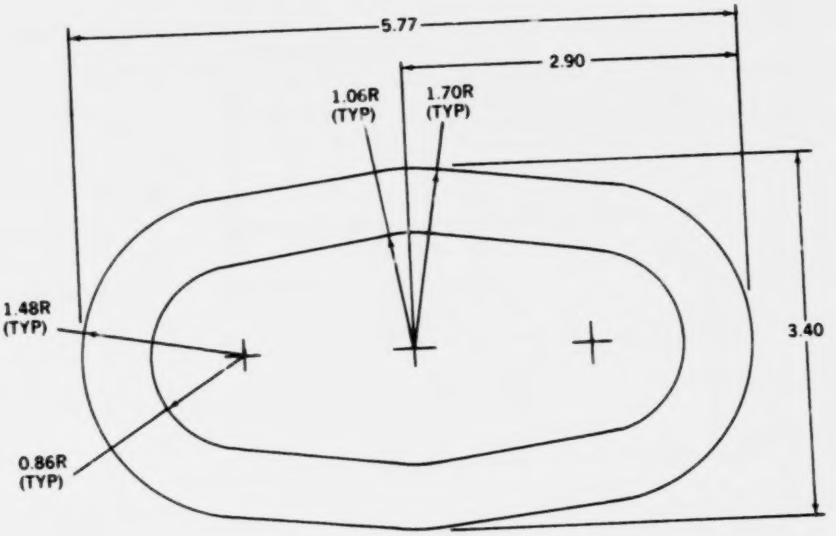
NOTES:

1. MAKE FROM GRADE M RUBBER, MIL-R-46089, NSN 5330-01-100-1708.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70500-03050-108, -153 STATION 398 BULKHEAD PANEL INSTALLATION SEAL.

FIGURE H-81. SEAL



S 79762 (C17)

NOMENCLATURE	T THICKNESS	DIMENSIONS	SIKORSKY PART NUMBER
CEILING DRIP PAN SEAL	0.25	AS SHOWN	70500-02060-202

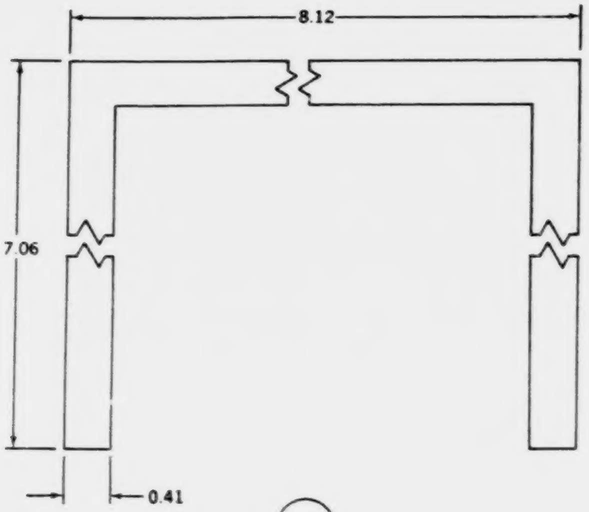
NOTES:

1. MAKE FROM MIL-STD-670 SCE 3L CD1079E, 0.25 INCH THICK, NSN 9320-00-234-4073.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PART PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE YELLOW INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

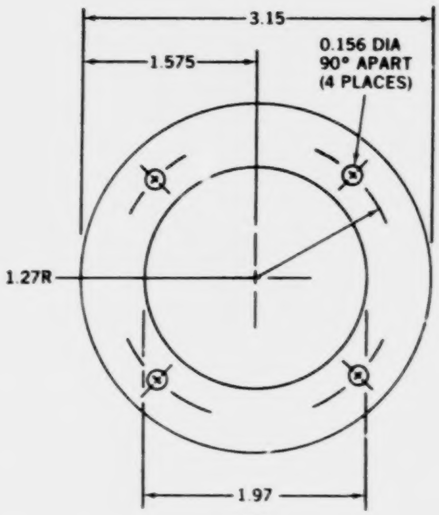
EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70500-02060-202 CEILING DRIP PAN SEAL.

FIGURE H-82. CEILING DRIP PAN SEAL



-205



-206

S 79763 (C17)

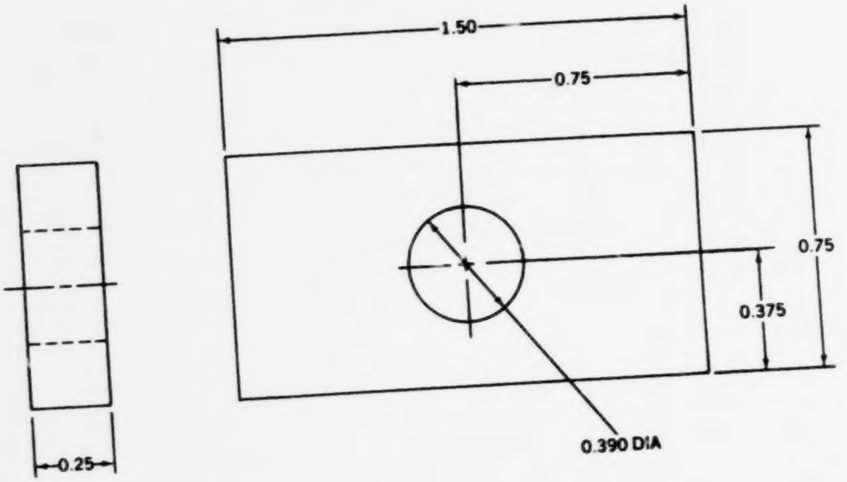
NOMENCLATURE	T THICKNESS	DIMENSIONS	SIKORSKY PART NUMBER
CEILING DRIP PAN SEALS	0.125	AS SHOWN	70500-02060-205
			70500-02060-206

NOTES:
1. MAKE FROM MIL-STD-670, SCE 3L CD1079, 0.125 INCH THICK, NSN 9320-01-154-2225.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE YELLOW INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70500-02060-205, -206 CEILING DRIP PAN SEALS.

FIGURE H-83. CEILING DRIP PAN SEAL



NOMENCLATURE	T THICKNESS	DIMENSIONS	SIKORSKY PART NUMBER
CEILING DRIP PAN SEAL	0.25	AS SHOWN	70500-02060-222

NOTES:

1. MAKE FROM NITRILE RUBBER, MIL-R-6855, CLASS 1, GRADE 40, 0.25 INCH THICK, NSN 9320-01-157-9071.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PART PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE YELLOW INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86

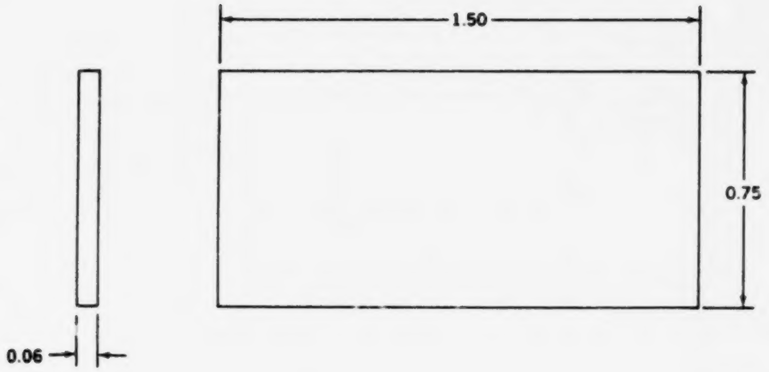
PART NUMBER

1986

THIRD QUARTER

PART NUMBER: 70500-02060-222 SEAL.

FIGURE H-84. CEILING DRIP PAN SEAL



S 79765 (C17)

NOMENCLATURE	T THICKNESS	DIMENSIONS	SIKORSKY PART NUMBER
CEILING DRIP PAN SEAL	0.06	AS SHOWN	70500-02060-223

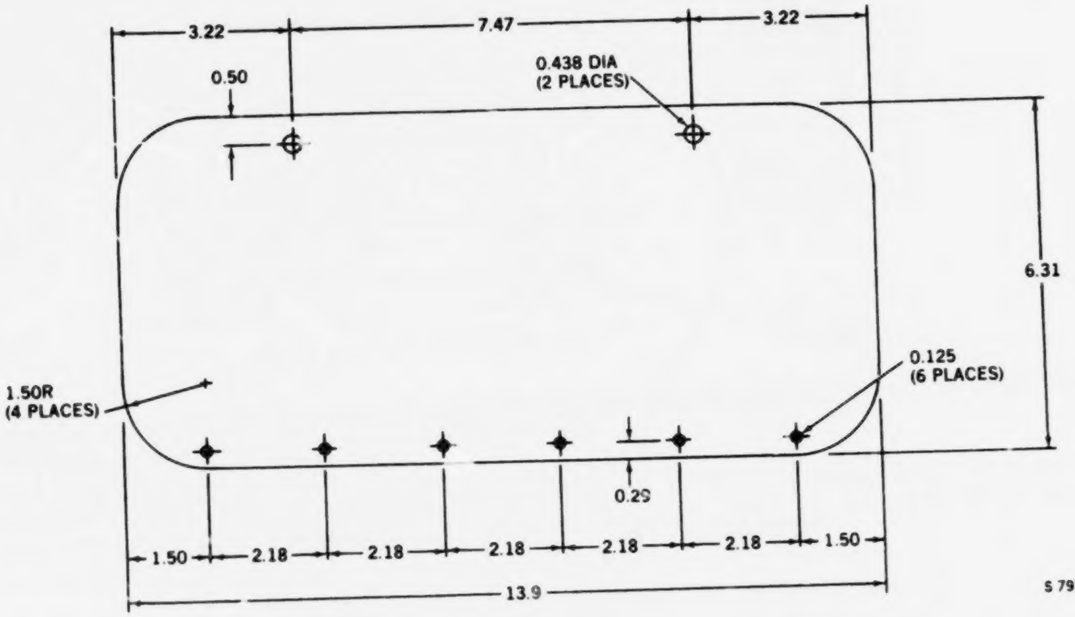
NOTES:

1. MAKE FROM NITRILE RUBBER, MIL-R-6855, CLASS 1, GRADE 40, 0.06 INCH THICK, NSN 9320-00-241-9741.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PART PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE YELLOW INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER
1986
THIRD QUARTER

PART NUMBER: 70500-02060-223 SEAL.

FIGURE H-85. CEILING DRIP PAN SEAL


3.22
7.47
3.22
0.50
0.438 DIA
(2 PLACES)
6.31
0.125
(6 PLACES)
1.50R
(4 PLACES)
0.29
1.50
2.18
2.18
2.18
2.18
2.18
1.50
13.9

S 79766 (C17)

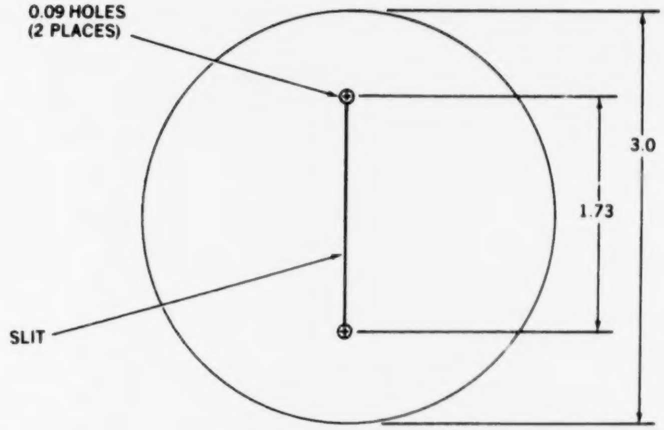
NOMENCLATURE	SIKORSKY PART NUMBER
CEILING PANEL DOOR	70500-02062-136

NOTES:

1. MAKE FROM CEL ACETATE BUTERATE, 0.125 INCH THICK, NSN 9320-01-024-1549.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 70500-02062-136 CEILING PANEL DOOR.

FIGURE H-86. CEILING PANEL DOOR



S 79767 (C17)

NOMENCLATURE	SIKORSKY PART NUMBER
CEILING PANEL GASKET	70500-02062-150

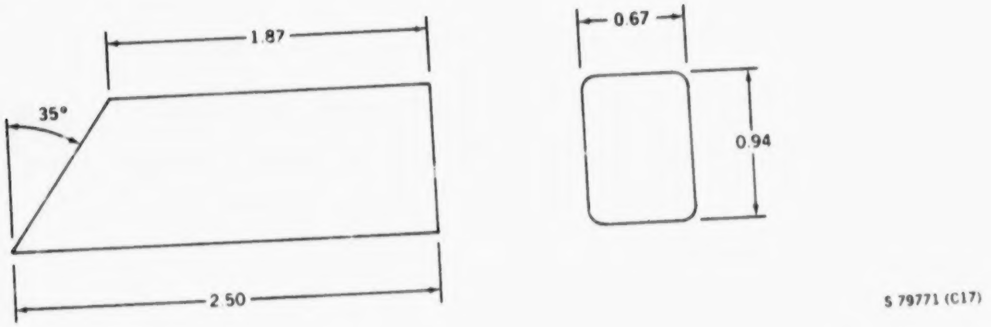
NOTES:

1. MAKE FROM RUBBER, MIL-R-6855, CLASS 1, GRADE 60, 0.062 INCH THICK, NSN 9320-00-241-9742. ALTERNATE RUBBER, MIL-R-6855 CLASS 2, GRADE 60, 0.062-INCH THICK, NSN 9320-01-157-9070.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70500-02062-150 CEILING PANEL GASKET.

FIGURE H-87. CEILING PANEL DOOR


1.87
35°
2.50
0.67
0.94
S 79771 (C17)

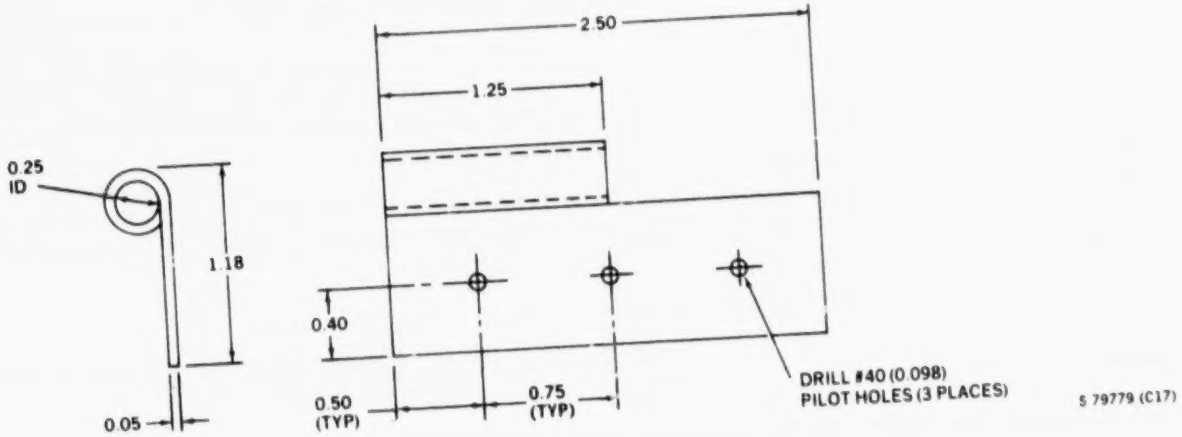
NOTES:

1. MAKE SEAL PER FIGURE FROM S1509-20016-1 EXTRUDED SILICONE SPONGE RUBBER, AMS3195, NSN 5330-01-162-2778.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER
1986
THIRD QUARTER

PART NUMBER: 70215-02312-106 MAIN LANDING GEAR FAIRING SEAL.

FIGURE H-88. MAIN LANDING GEAR FAIRING SEAL

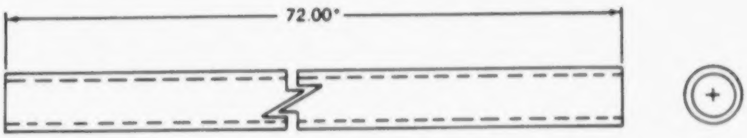

2.50
1.25
0.25
ID
1.18
0.40
0.50
(TYP)
0.75
(TYP)
0.05
DRILL #40 (0.098)
PILOT HOLES (3 PLACES)
S 79779 (C17)

NOTES:

1. MAKE FROM H1004D13NL HINGE HALF, NSN 5340-01-116-4537.
2. DRILL #40 PILOT HOLES PER FIGURE AND TM 55-1500-204-25/1.
3. ALL DIMENSIONS ARE IN INCHES.
4. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 70500-02068-118 SIDE WALL PANEL HINGE.

FIGURE H-89. SIDE WALL PANEL HINGE



*OVERSIZE - TRIM UPON INSTALLATION

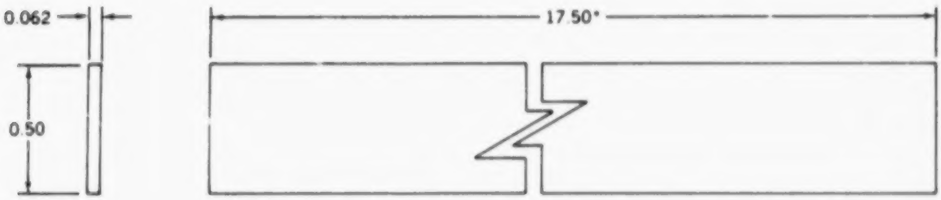
S 79780 (C17)

NOTES:

1. MAKE FROM TYGOTHANE — 1/4 TUBING, 0.375 OD x 0.250 ID PER MIL-R-83397, NSN 4720-01-004-8081.
2. ALL DIMENSIONS ARE IN INCHES.
3. CUT TUBING TO 72 INCHES, AS SHOWN.
4. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 70070-30112-164 EXTENDED RANGE FUEL KIT CONTAINER INSTALLATION TUBE.

FIGURE H-90. TUBE



*OVERSIZE - TRIM ON INSTALLATION

S 79782 (C17)

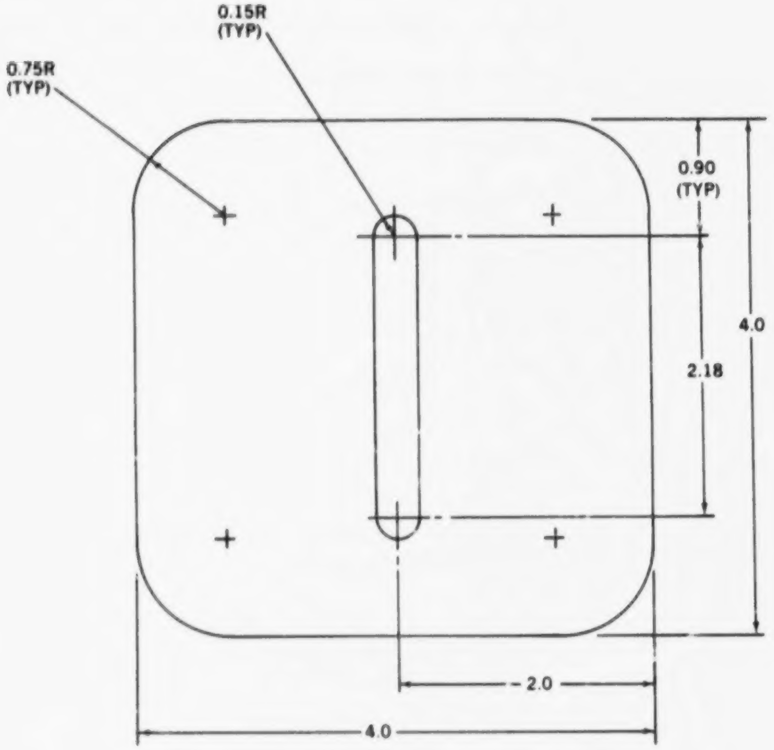
NOTES:

1. MAKE SEAL FROM 0.062 INCH THICK, SCE 7L RUBBER SHEET, PER MIL-STD-670, NSN 9320-00-012-3481.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER
1986
THIRD QUARTER

PART NUMBER: 70500-02054-104 COVER SEAL, STATION 247.

FIGURE H-91. COVER SEAL



S 79789 (C17)

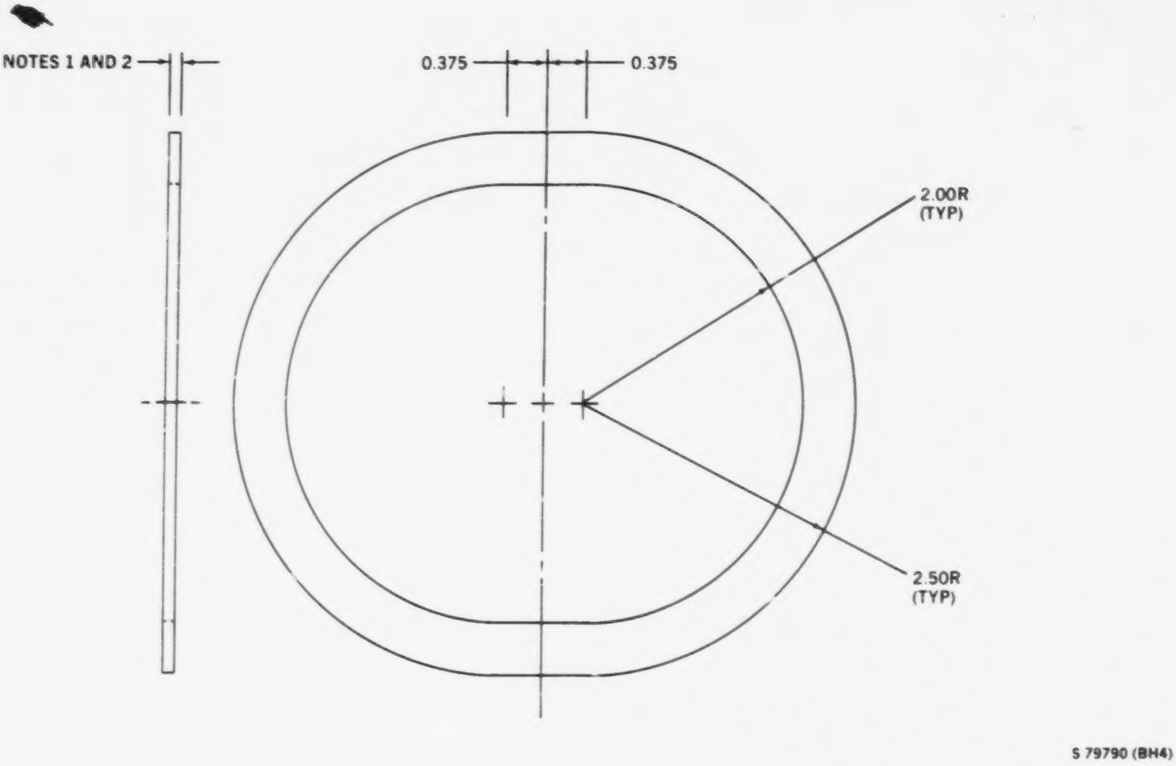
NOTES:

1. MAKE FROM 0.125 INCH THICK, CLASS 1, GRADE 40, NITRILE RUBBER SHEET, MIL-R-6855, NSN 9320-00-059-6504.
2. ALL DIMENSIONS ARE IN INCHES.
3. CUT SLOT IN SEAL AS SHOWN IN FIGURE.
4. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE YELLOW INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70500-02070-111 CEILING DRIP PAN SEAL.

FIGURE H-92. CEILING DRIP PAN SEAL


NOTES 1 AND 2
0.375
0.375
2.00R (TYP)
2.50R (TYP)
S 79790 (BH4)

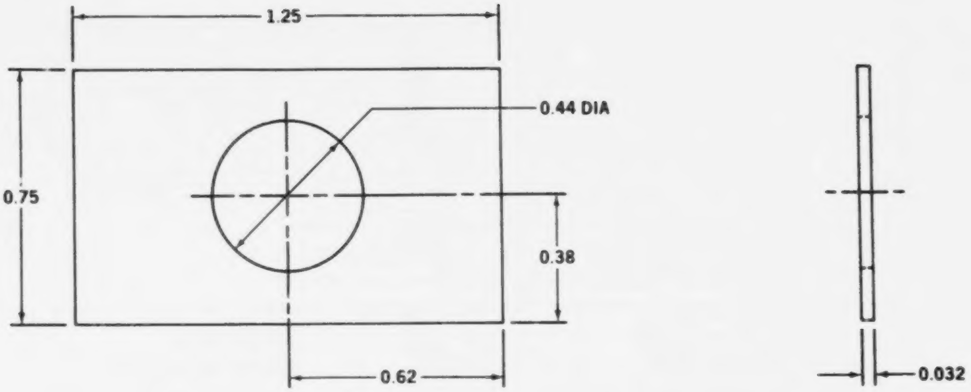
NOTES:

1. MAKE FROM 0.125 INCH THICK SCE-3L RUBBER SHEET, MIL-STD-670, NSN 9320-01-154-2225.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE YELLOW INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70500-02070-109 DRIP PAN SEAL.

FIGURE H-93. DRIP PAN SEAL



S 79791 (C17)

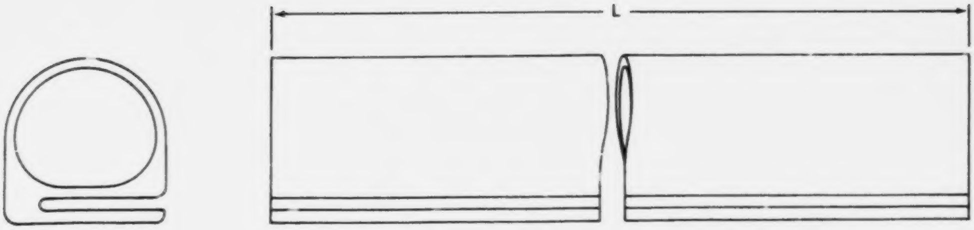
NOTES:

1. MAKE FROM NITRILE RUBBER, MIL-R-6855, CLASS 2, GRADE 60, 0.032 INCH THICK, NSN 9320-01-157-9069. ALTERNATE NITRATE RUBBER, MIL-R-6855, CLASS 1, GRADE 60, 0.032-INCH THICK, NSN 9320-01-102-3060.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE YELLOW INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70500-02071-111 DRIP PAN SEAL.

FIGURE H-94. DRIP PAN SEAL



S 79793 (C17)

NOMENCLATURE	L LENGTH	SIKORSKY PART NUMBER
SEAL CARGO DOOR	36.34	70217-02721-109
	15.20	70217-02721-111

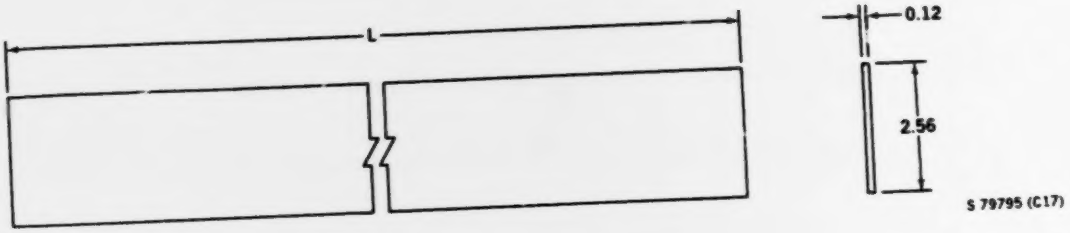
NOTES:

1. MAKE FROM RUBBER EXTRUSION, NSN 9390-00-792-1501.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70217-02721-109, -111 CARGO DOOR SEAL.

FIGURE H-95. CARGO DOOR SEAL



DASH NO.	LENGTH (L)
-107	13.75
-108	13.00

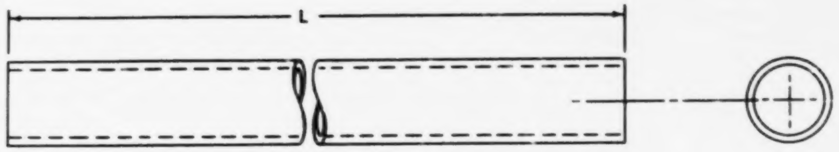
NOTES:

1. MAKE FROM 0.125 INCH THICK, SCE-3L RUBBER, MIL-STD-670, NSN 9320-01-154-2225.
2. ALL DIMENSIONS ARE IN INCHES.
3. CUT -107 AND -108 SEALS TO SIZE PER CHART IN FIGURE.
4. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70500-02072-107, -108 CEILING PANEL SEAL.

FIGURE H-96. CEILING PANEL SEAL



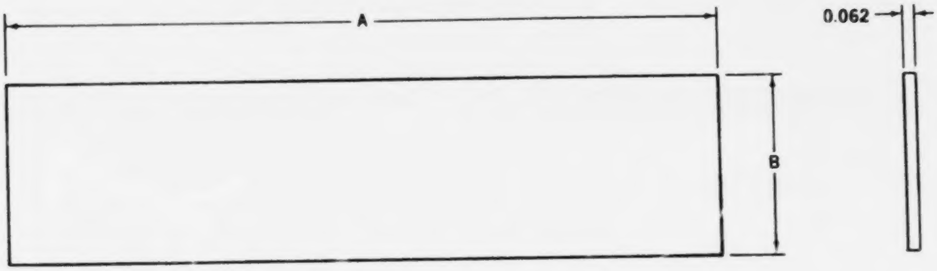
S 79797 (C17)

PART NUMBER	LENGTH (L)	MAKE FROM	NSN NUMBER
70550-02151-101	6.50	TEMFLEX 105C 1/2 INCH ID CLEAR (75037)	5970-00-685-9057
70550-02151-102	8.25		

NOTES:
1. MAKE FROM 0.50 ID x 0.062 WALL THICKNESS, CLEAR TUBING, USING LENGTH AND MATERIAL LISTED IN CHART.
2. ALL DIMENSIONS ARE IN INCHES.
3. DEBURR BOTH ENDS TO FORM SMOOTH ROUNDED SURFACE.
4. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 70550-02151-101, -102 ELECTRICAL WIRING CONDUIT.

FIGURE H-97. ELECTRICAL WIRING



S 79801 (C17)

DASH NO.	LENGTH (A)	WIDTH (B)
-107	4.50	2.36
-108	18.00	5.50

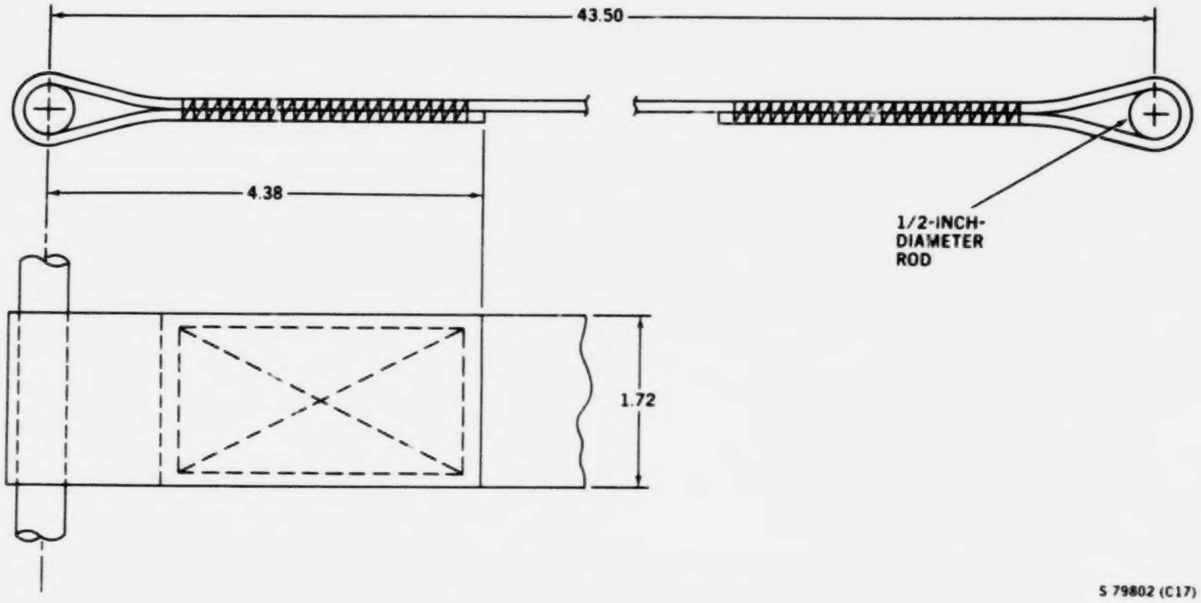
NOTES:

1. MAKE FROM 0.062 INCH THICK, CLASS 2, GRADE 50, RUBBER MIL-R-6855, NSN 9320-00-202-1322.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70700-20395-107, -108 GRIP.

FIGURE H-98. GRIP

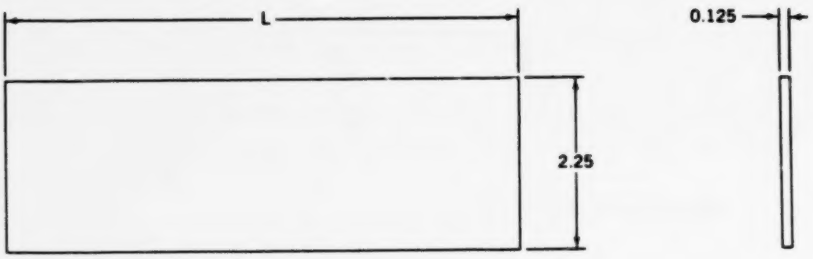


NOTES:

1. MAKE FROM 1.72-INCH-WIDE NYLON WEBBING PER MIL-W-4088, TYPE XIII COLOR OLIVE DRAB, NSN 8305-00-260-4585. OVERALL LENGTH BEFORE SEWING IS 53.83 INCHES.
2. ALL DIMENSIONS ARE IN INCHES.
3. STITCHING SHALL BE DONE IN ACCORDANCE WITH FED-STD-NO. 751. ALL SEWING TO BE DONE WITH STITCH 301. THERE SHALL BE NO LESS THAN 8 NOR MORE THAN 10 STITCHES PER INCH. ENDS OF ALL STITCHING SHALL BE BACK STITCHED NOT LESS THAN 1/2 INCH.
4. STITCH ENDS USING FED. SPEC V-T-295 NYLON THREAD TYPE I, CLASS 2, SIZE E, NSN 8310-00-262-2772.
5. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 70700-20420-116 NYLON WEBBING STRAP.

FIGURE H-99. NYLON WEBBING STRAP



S 79805 (C17)

PART NUMBER	LENGTH (L)
70700-20313-106	20.50
70700-20313-107	9.50
70700-20313-108	12.312

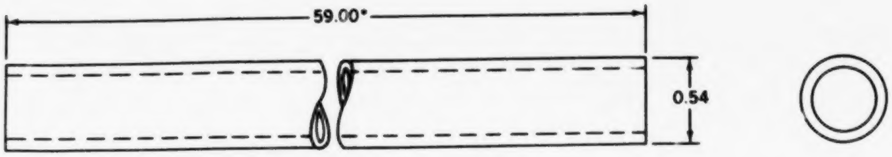
NOTES:

1. MAKE FROM 0.125 INCH THICK, TYPE 2, GRADE A, MEDIUM RUBBER, MIL-R-61308, NSN 9320-01-180-0251.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70700-20313-106, -107, -108 PAD.

FIGURE H-100. PAD



*TRIM ON INSTALLATION

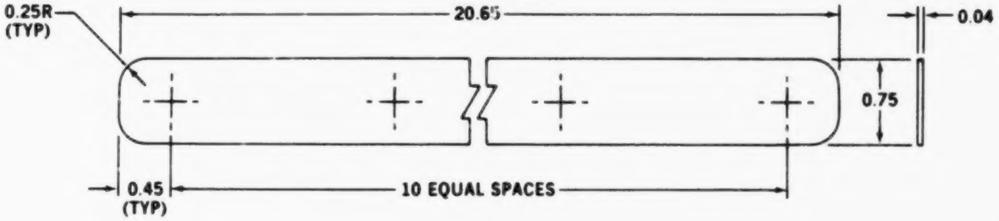
S 79806 (C17)

NOTES:

1. MAKE FROM 0.500 ID x 0.020 WALL CONVOLEX TUBING, NSN 9330-01-089-0116.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 70500-02065-103 TUBE.

FIGURE H-101. TUBE



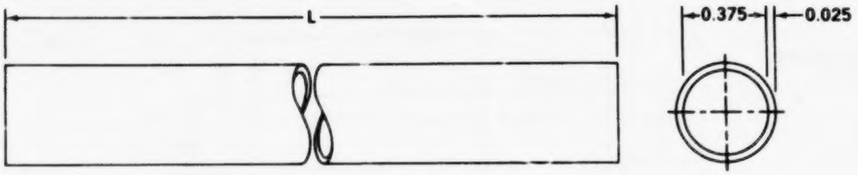
S 79808 (C17)

NOTES:

1. MAKE FROM 0.040 INCH THICK, 7075-T6 ALCLAD SHEET, QQ-A-250/13, NSN 9535-00-084-4581.
2. ALL DIMENSIONS ARE IN INCHES.
3. LOCATE HOLES ON INSTALLATION.
4. TREAT CUT EDGES WITH CORROSION RESISTANT COMPOUND (ALODINE) MIL-C-5541, NSN 8030-00-811-3723.
5. FINISH PER MIL-P-23377 EPOXY PRIMER, NSN 8010-00-082-2477, 1 COAT, FED. SPEC TT-L-20 DULL BLACK LAQUER, NSN 8010-00-664-7651, 2 COATS.
6. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 70500-02068-123 STIFFENER.

FIGURE H-102. STIFFENER



S 79809 (C17)

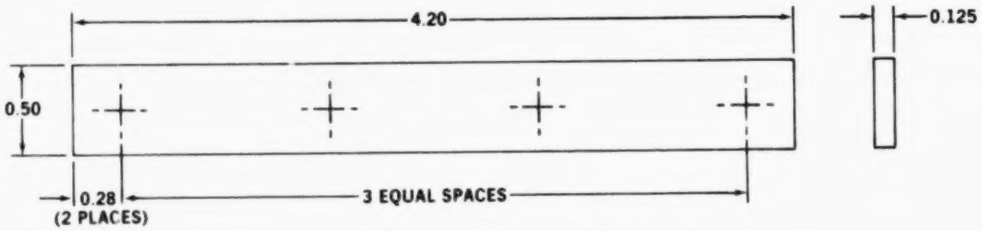
SIKORSKY PART NUMBER	LENGTH (L)	MAKE FROM	NSN
70551-07000-103 TAIL ROTOR CABLE CONDUIT	67.25	TEMFLEX 105C 3/8 INCH ID CLEAR (75037)	5970-00-889-3844

NOTES:

1. MAKE PARTS FROM 0.375 ID x 0.025 WALL THICKNESS TUBING USING MATERIAL AND LENGTH FROM CHART.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 70551-07000-103 TAIL ROTOR CABLE CONDUIT.

FIGURE H-103. TAIL ROTOR PYLON CONDUIT



S 79811 (C17)

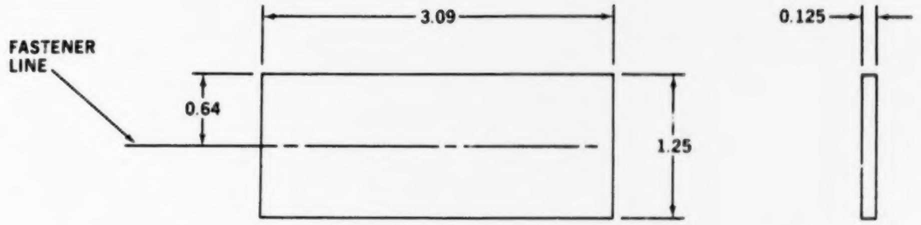
NOTES:

1. MAKE FROM 0.125-INCH-THICK SPONGE, SCE 3L, MIL-STD-670, NSN 9320-01-154-2225.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70217-02701-113 SEAL.

FIGURE H-104. SEAL



S 79814 (C17)

NOMENCLATURE	SIKORSKY PART NUMBER
CARGO DOOR SEAL	70217-02721-143

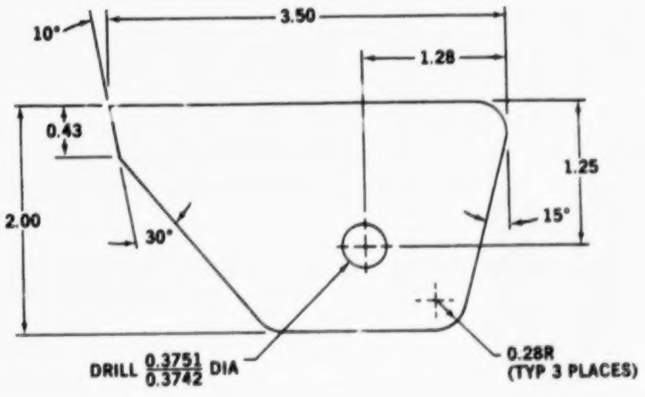
NOTES:

1. MAKE FROM MIL-R-6855, CLASS 2, GRADE 60, 0.125 INCH THICK, NSN 9320-00-241-9758.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER
1986
THIRD QUARTER

PART NUMBER: 70217-02721-143 CARGO DOOR SEAL.

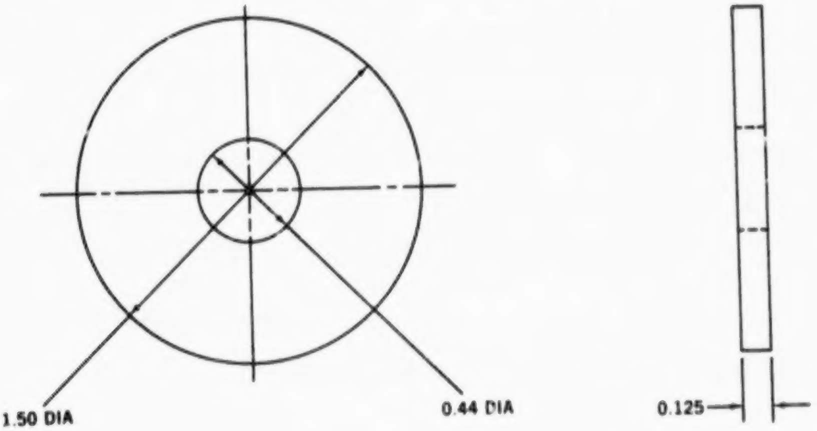
FIGURE H-105. CARGO DOOR SEAL


10°
3.50
1.28
0.43
1.25
2.00
30°
15°
DRILL $\frac{0.3751}{0.3742}$ DIA
0.28R
(TYP 3 PLACES)
S 79816 (C17)

NOTES:
1. MAKE FROM 0.040 INCH THICK, 7075-T6 ALCLAD SHEET, QQ-A-250/13, NSN 9535-00-084-4581.
2. DRILL BUSHING HOLE TO DIMENSION SHOWN IN FIGURE.
3. CHEMICAL SURFACE TREAT CUT EDGES AND DRILLED HOLES PER MIL-C-5541.
4. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 70217-01003-151 CREW DOOR DOUBLER.

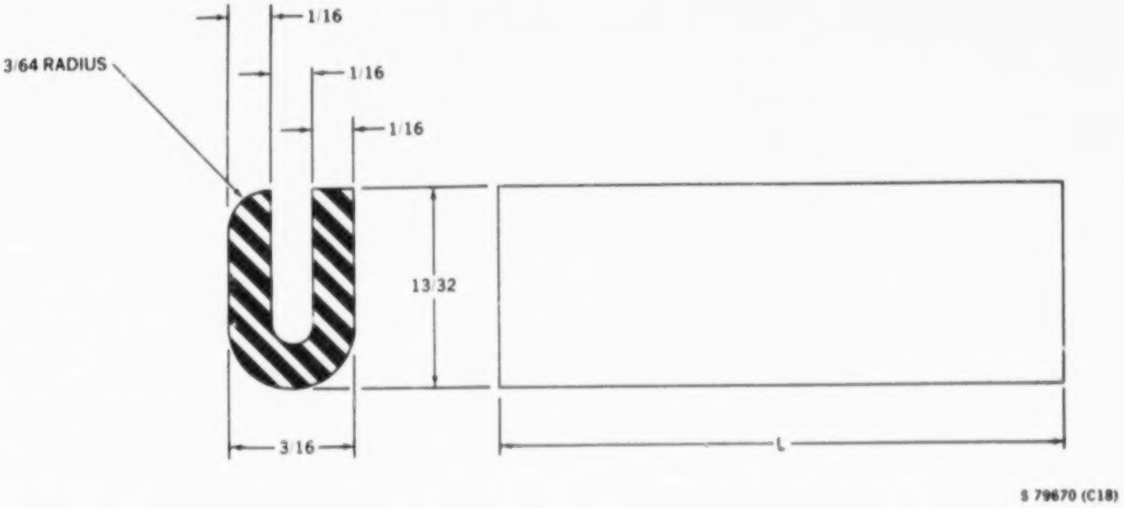
FIGURE H-106. CREW DOOR DOUBLER


1.50 DIA
0.44 DIA
0.125
S 79818 (C17)

NOTES:
1. MAKE FROM 0.125 INCH THICK NYLON 6/6, L-P-410, NSN 9330-01-028-9334.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 70700-20507-105 WASHER.

FIGURE H-107. WASHER



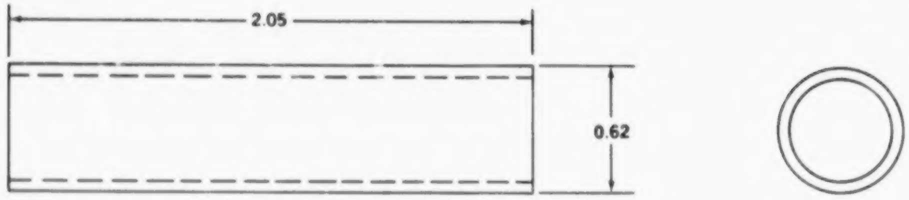
PART NUMBER	LENGTH (L)
SS2940-1	1.00 IN.
SS2940-2	2.00 IN.

NOTES:
1. MAKE FROM SS2940-120 SYNTHETIC RUBBER EDGING, RS709ABDFFZ, MIL-R-3065, FSCM 78286.
2. ALL DIMENSIONS ARE IN INCHES.
3. DASH NUMBER REPRESENTS LENGTH OF EDGING IN INCHES.
4. CUT EDGING TO REQUIRED SIZE PER CHART.
5. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: SS2940-1, SS2940-2 RUBBER EDGING.

FIGURE H-108. RUBBER EDGING

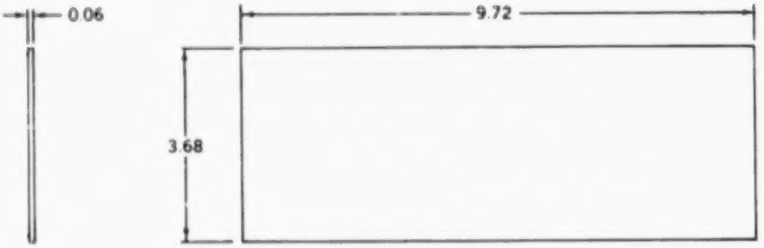


S 79678 (C18)

NOTES:
1. MAKE FROM 0.62-INCH-DIAMETER OD x 0.049-INCH THICK WALL, 6061-T6 ALUMINUM ALLOY TUBING, WW-T-700/6, NSN 4710-01-044-6567.
2. ALL DIMENSIONS ARE IN INCHES.
3. DEBURR INSIDE AND OUTSIDE OF CUT ENDS.
4. IDENTIFY PART PER MIL-STD-130.

PART NUMBER: 70500-02073-101 DRIP PAN TUBE.

FIGURE H-109. DRIP PAN TUBE



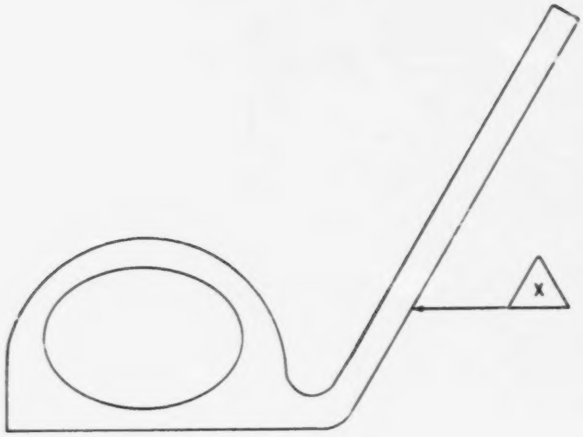
S 79679 (C18)

NOTES:
1. MAKE FROM 0.062-INCH-THICK, CLASS 3B, GRADE 50 RUBBER, ZZ-R-765, NSN 9320-01-032-6281.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70700-20324-105 CUSHION.

FIGURE H-110. CUSION



S 79686 (C18)

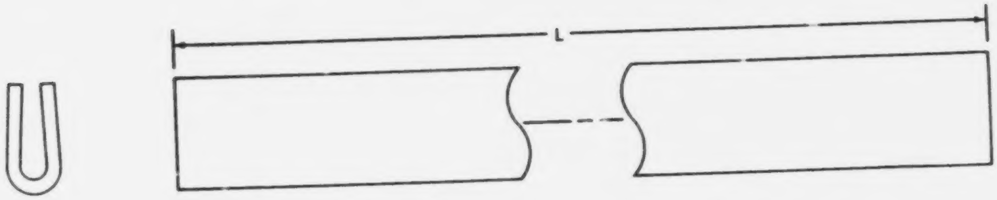
NOTES:

1. MAKE FROM 38010-70023-101 EXTRUDED NITRILE RUBBER, CLASS 1, GRADE 40, MIL-R-6855, FSCM 78286.
2. ALL DIMENSIONS ARE IN INCHES.
3. MINIMUM LENGTH 80.0 INCHES. TRIM TO FIT ON INSTALLATION.
4. IDENTIFY PARTS PER MIL-STD-190 AT LOCATION MARKED BY △x IN F/D. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70308-03602-109 INLET DOOR SEAL.

FIGURE H-111. HIRSS INLET DOOR SEAL



S 79688 (C18)

NOMENCLATURE	L LENGTH	SIKORSKY PART NUMBER
BATTERY BOX COVER SEALS	1.87	70209-02532-105
	1.75	70209-02532-106
	4.87	70209-02532-107
	10.87	70209-02532-110
	11.75	70209-02532-111
	1.37	70209-02532-112
	2.00	70209-02532-113

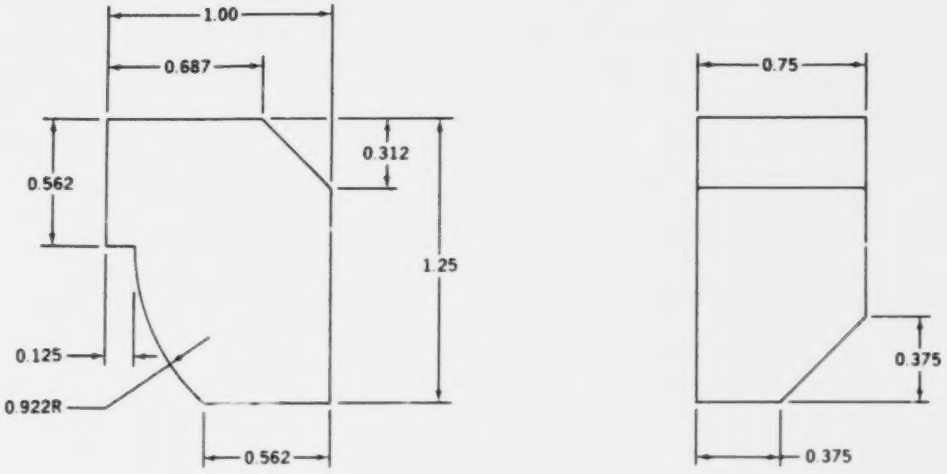
NOTES:

1. MAKE FROM SYNTHETIC RUBBER EXTRUSION, DIE NO. 535, FSCM 19864. CUT TO LENGTH PER DIMENSIONS IN CHART.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70209-02532-105 THRU -107 AND -110 THRU -113 BATTERY BOX COVER SEALS.

FIGURE H-112. BATTERY BOX COVER SEALS


1.00
0.687
0.562
0.312
1.25
0.125
0.922R
0.562
0.75
0.375
0.375

S 79702 (C18)

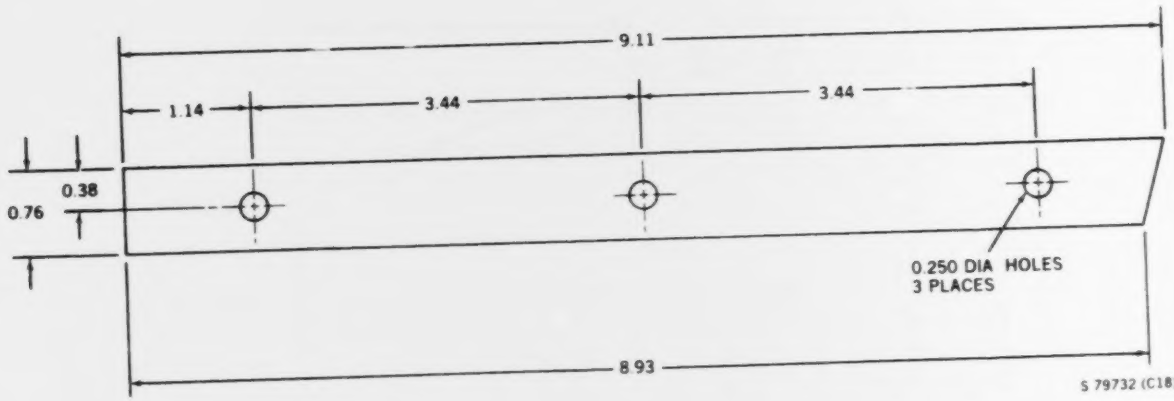
NOTES:

1. MAKE FROM 0.50-INCH-THICK SILICONE SPONGE, AMS 3195, NSN 9320-01-037-2499.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70216-02401-129 GUNNER'S WINDOW SEAL.

FIGURE H-113. GUNNER'S WINDOW SEAL



NOMENCLATURE	SIKORSKY PART NUMBER
TRANSMISSION DRIP PAN SEAL	70070-50005-112

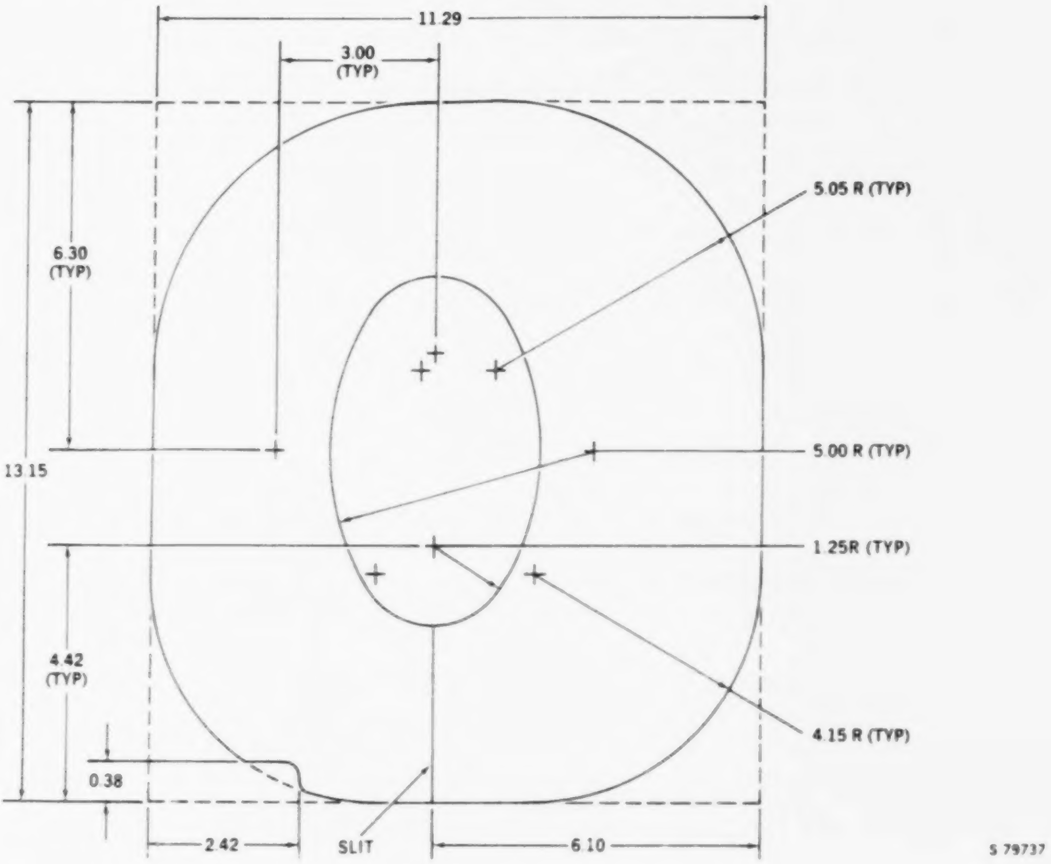
NOTES:

1. MAKE FROM 0.187-INCH-THICK SCE-3L, CD1079 RUBBER, MIL-C-3133, NSN 9320-00-815-9734.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PART PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE YELLOW INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70070-50005-112 TRANSMISSION DRIP PAN SEAL.

FIGURE H-114. TRANSMISSION DRIP PAN SEAL


11.29
3.00
(TYP)
5.05 R (TYP)
6.30
(TYP)
13.15
5.00 R (TYP)
1.25R (TYP)
4.42
(TYP)
4.15 R (TYP)
0.38
2.42
SLIT
6.10
S 79737

NOMENCLATURE	SIKORSKY PART NUMBER
MAIN GEAR STRUT WELL SEAL	70215-02312-102

NOTES:

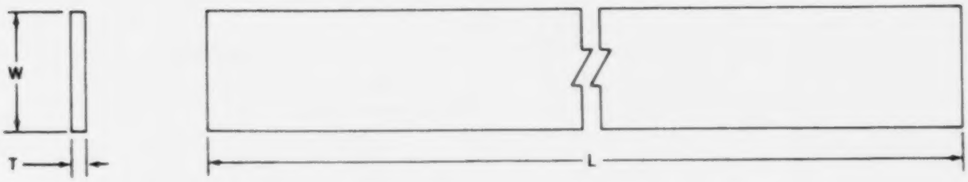
1. MAKE FROM 0.25-INCH-THICK NON-POROUS SKINNED RUBBER, CLASS 1, GRADE 40, MIL-R-6855, NSN 9320-01-157-9071.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 — PART NUMBER

3Q 86 — 3Q: THIRD QUARTER; 86: 1986

PART NUMBER: 70215-02312-102 MAIN GEAR STRUT WELL SEAL.

FIGURE H-115. BEADED TUBE



S 79733 (C18)

SIKORSKY PART NUMBER	T THICKNESS	W WIDTH	L LENGTH	NSN
70216-01007-117	0.25	0.65	13.19	5330-01-105-5866
70216-01007-118	0.06	0.32	13.03	5330-01-105-5866
70216-01007-158	0.12	0.49	12.78	9320-00-202-1935
70216-01007-174	0.06	0.49	4.70	9320-00-080-7382

NOTES:

1. MAKE FROM SCE-7L RUBBER, MIL-STD-670, PER CHART.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

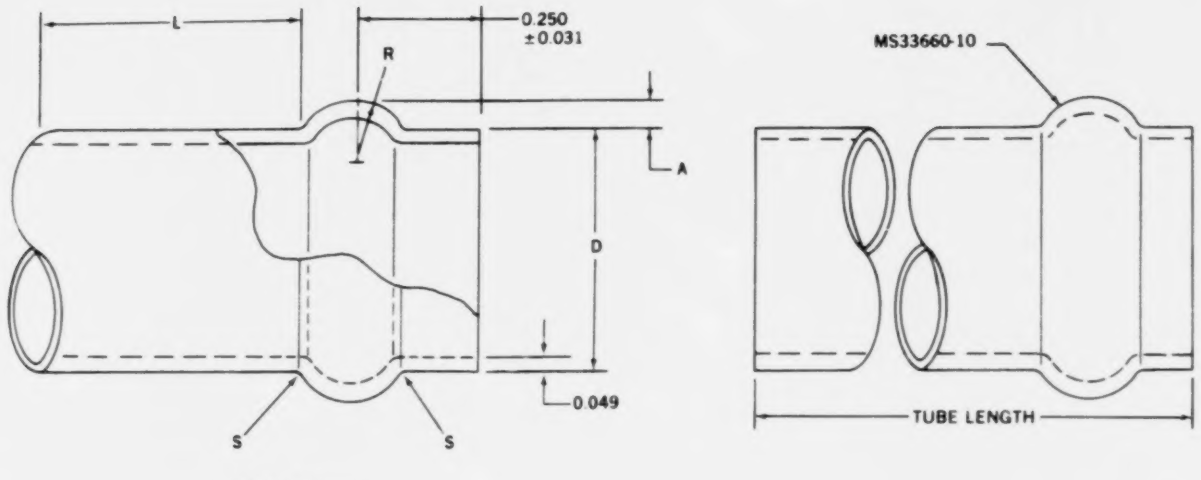
EXAMPLE: P/N 70216-02401-107 3Q 86

PART NUMBER 1986

THIRD QUARTER

PART NUMBER: 70216-01007-117, -118, -158, -174 VENT WINDOW SEAL.

FIGURE H-116. VENT WINDOW SEALS


L
0.250
±0.031
R
A
D
0.049
S
S
MS33660-10
TUBE LENGTH

TYPE A END

S 79738

CHART A

BEAD SIZE	D (NOTE a) TUBE OD	D (NOTE a) TOLERANCE FOR LENGTH L TYPE A END	A BEAD HEIGHT ±0.003	L LENGTH MIN. (NOTE a)	R BEAD RADIUS MAX	S BEAD EDGE RADIUS MAX
MS33660-10	0.625	+0.003 −0.010	0.038	0.750	0.125	0.062

a. TUBE OD, AFTER BEADING, SHALL BE MAINTAINED FOR DISTANCE L.

FIGURE H-117. MAIN GEAR STRUT WELL SEAL (SHEET 1 OF 2)

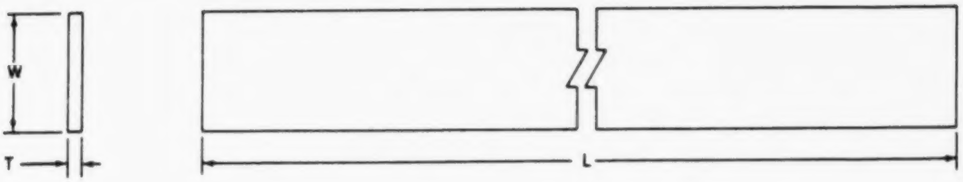
CHART B

DASH NO.	TUBE LENGTH
−109	7.00 INCH
−110	5.25 INCH

NOTES:
1. MAKE FROM 0.625 OD x 0.049 WALL THICKNESS, 5052-0 ALUMINUM ALLOY TUBING, WW-T-700/4, FSCM 81349.
2. FORM BEAD AS SHOWN, PER MS33660-10 AND CHART A.
3. ALL DIMENSIONS ARE IN INCHES.
4. CUT TUBE LENGTH PER CHART B, AND DEBURR CUT ENDS.
5. TREAT TUBE WITH CORROSION-RESISTANCE COMPOUND (ALODINE), MIL-C-81706, NSN 8030-00-811-3723.
6. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 70500-02071-109 SLIDE AND 70500-02071-110 TUBE, DRIP PAN COVER ASSEMBLY.

FIGURE H-117. MAIN GEAR STRUT WELL SEAL (SHEET 2 OF 2)



S 79745 (C18)

NOMENCLATURE	T THICKNESS	W WIDTH	L LENGTH	SIKORSKY PART NUMBER
CARGO DOOR JETTISON WINDOW SEALS	0.062	0.532	102.25	70217-02705-108 70217-02705-112
			19.00	70217-02705-115

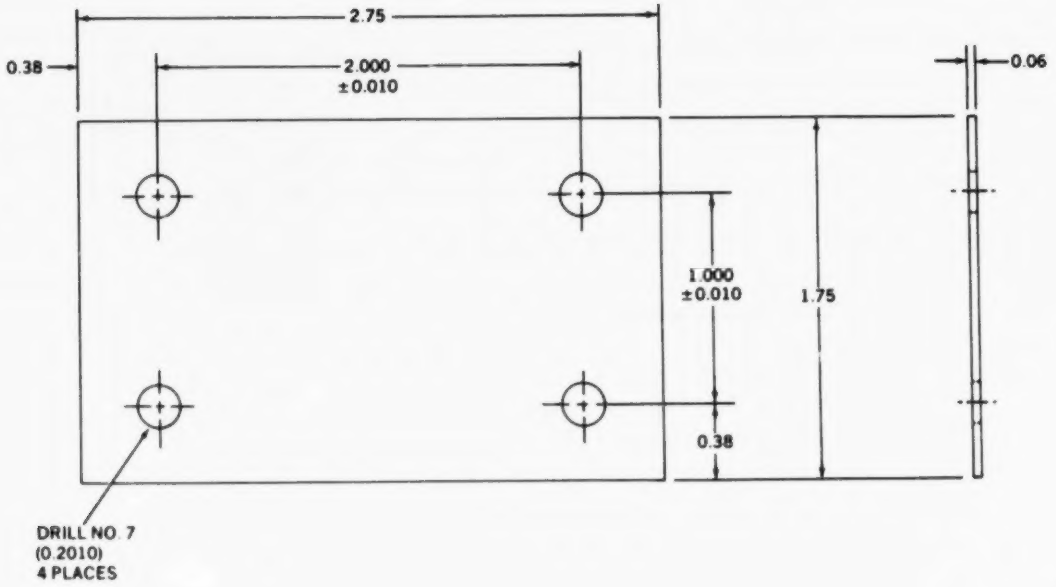
NOTES:

1. MAKE FROM 0.062-INCH-THICK RUBBER, TYPE 2, GRADE A, MEDIUM, MIL-STD-670B SCE7L, NSN 9320-00-012-3481.
2. ALL DIMENSIONS ARE IN INCHES.
3. CUT SEALS TO SIZE PER CHART. CUT OVERSIZE TO ALLOW FOR FINAL FIT ON INSTALLATION.
4. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70217-02705-108, -112, -115 CARGO DOOR JETTISON WINDOW SEALS.

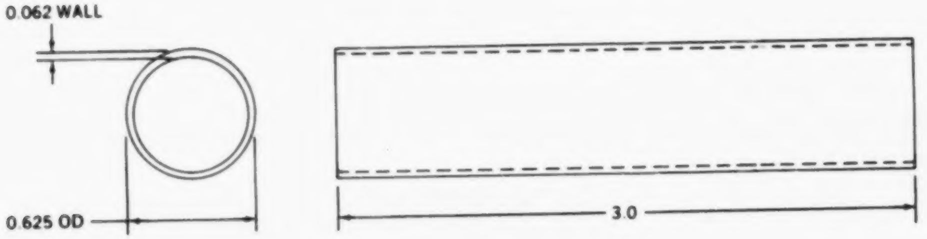
FIGURE H-118. CARGO DOOR JETTISON WINDOW SEAL


2.75
0.38
2.000
±0.010
0.06
1.000
±0.010
1.75
0.38
DRILL NO. 7
(0.2010)
4 PLACES
S 79746 (C18)

NOTES:
1. MAKE FROM 0.063-INCH-THICK 7075-T6 ALCLAD SHEET, QQ-A-250/13, NSN 9535-00-086-9860.
2. ALL DIMENSIONS ARE IN INCHES.
3. DRILL HOLES AS SHOWN PER TM 55-1500-204-25/1.
4. BREAK SHARP EDGES AND DEBURR ALL HOLES.
5. ANODIZE, TWO COATS, PER MIL-A-8625.
6. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 70217-01010-111 NOSE DOOR SHIM.

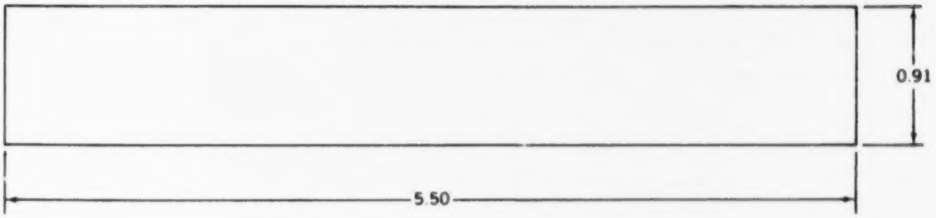
FIGURE H-119. SHIM


0.062 WALL
0.625 OD
3.0
S 79747 (C18)

NOTES:
1. MAKE FROM 0.625 OD x 0.500 ID, TYGON R-2807 PLASTIC TUBING, FSCM 34384.
2. CUT TO LENGTH, AS SHOWN.
3. IDENTIFY PART PER MIL-STD-130.

PART NUMBER: 70217-01010-110 NOSE DOOR SEAL SPLICE.

FIGURE H-120. SEAL SPLICE



S 79769 (C18)

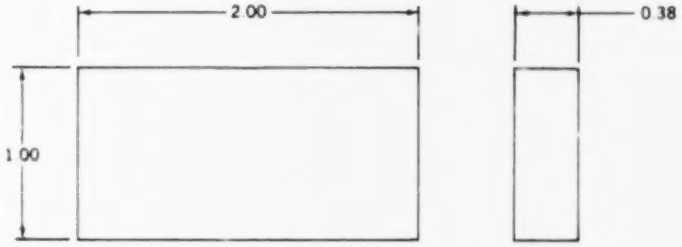
NOMENCLATURE	SIKORSKY PART NUMBER
CEILING PANEL STRAP	70500-02063-151

NOTES:

1. MAKE FROM NYLON WEBBING, CLASS 1, MIL-W-4088, COLOR GRAY, NSN 8305-01-015-5342.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 70500-02063-151 CEILING PANEL STRAP.

FIGURE H-121. CEILING PANEL STRAP



S 79772 (C18)

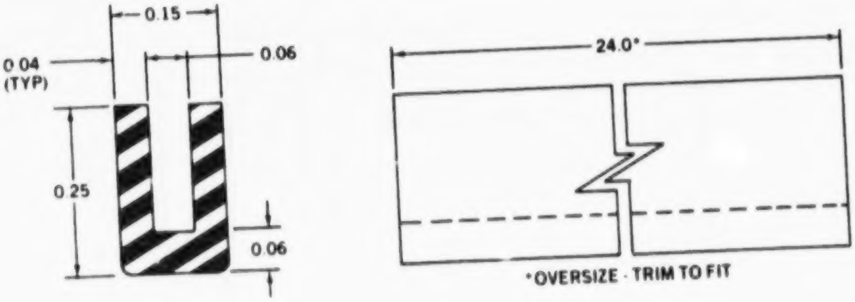
NOTES:

1. MAKE FROM 0.38-INCH-THICK NEOPRENE FOAM, SCE-3L, MIL-STD-670, NSN 9320-00-181-0016.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

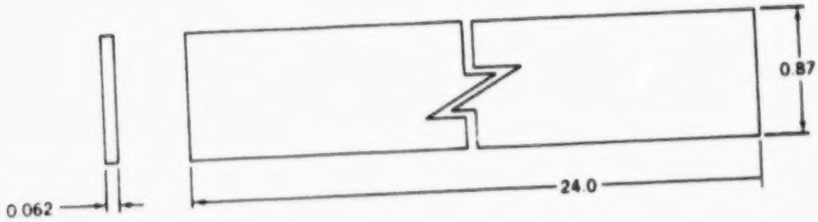
EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70215-02312-119 MAIN LANDING GEAR FAIRING BUMPER.

FIGURE H-122. MAIN LANDING GEAR FAIRING BUMPER



-102



-105

S 79773 (C18)

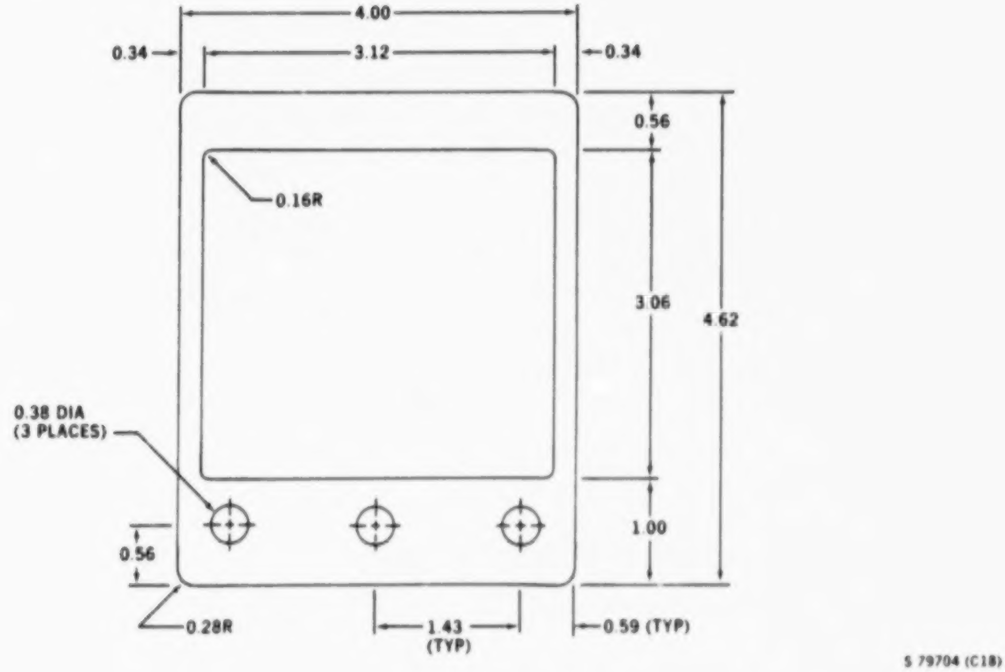
NOTES:

1. MAKE -102 SEAL FROM CH-383 EXTRUDED STYRENE BUTUDIENE RUBBER EDGING, FSCM 83473.
2. MAKE -105 SEAL (ALTERNATE SEAL) FROM 0.06-INCH-THICK RUBBER, CLASS 2, GRADE 60, MIL-R-6855, NSN 9320-01-157-9070.
3. ALL DIMENSIONS ARE IN INCHES.
4. ALTERNATE MATERIAL FOR -102 IS SS2940-24 SYNTHETIC RUBBER EDGING LISTED IN THIS APPENDIX. REFER TO INDEX.
5. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70215-02531-102, -105 LOWER FUSELAGE FAIRING SEAL.

FIGURE H-123. EDGING SEAL


4.00
0.34
3.12
0.34
0.56
0.16R
3.06
4.62
0.38 DIA
(3 PLACES)
1.00
0.56
0.28R
1.43
(TYP)
0.59 (TYP)
S 79704 (C18)

NOMENCLATURE	SIKORSKY PART NUMBER
DUCT INSTALLATION SEAL	70500-01053-113

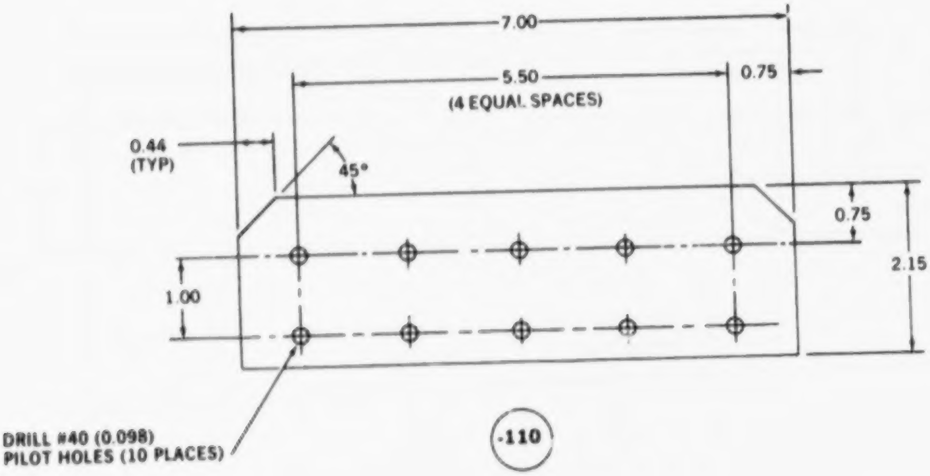
NOTES:

1. MAKE FROM 0.032-INCH-THICK RUBBER, CLASS 2, GRADE 60, MIL-R-6855, NSN 9320-01-157-9069.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-130. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GRAY INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

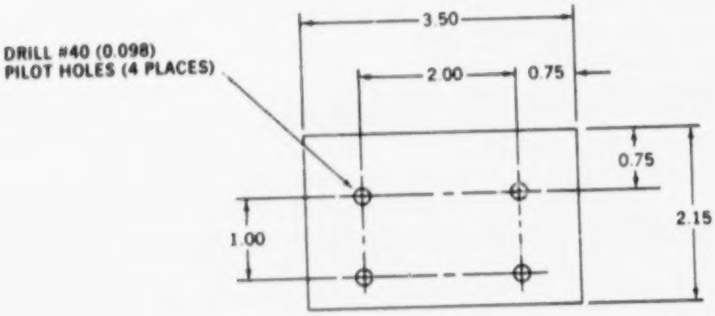
EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70500-01053-113 DUCT INSTALLATION SEAL.

FIGURE H-124. DUCT INSTALLATION SEAL


7.00
5.50
(4 EQUAL SPACES)
0.75
0.44
(TYP)
45°
0.75
2.15
1.00
DRILL #40 (0.098)
PILOT HOLES (10 PLACES)

-110


3.50
DRILL #40 (0.098)
PILOT HOLES (4 PLACES)
2.00
0.75
0.75
1.00
2.15

-109

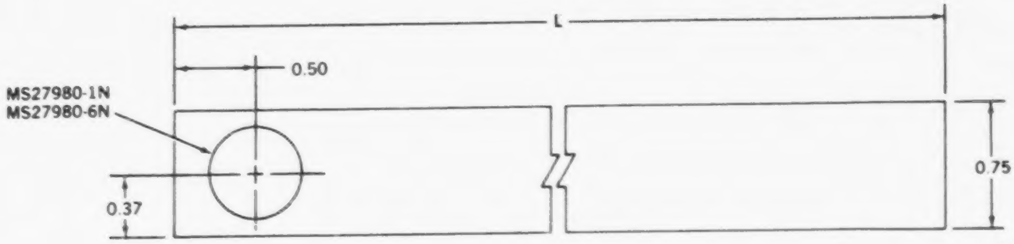
S 79781 (C18)

NOTES:

1. MAKE -109 AND -110 LINERS FROM 0.03-INCH THICK SYNTHANE GME, MIL-P-15037, NSN 5970-00-912-1907.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-130.
4. ON INSTALLATION OPEN PILOT HOLES TO 0.406-INCH DIAMETER TO MATCH VIBRATION ABSORBER HOLES.

PART NUMBER: 70219-02114-109, -110 VIBRATION ABSORBER LINERS.

FIGURE H-125. VIBRATION ABSORBER LINERS



S 79783 (C18)

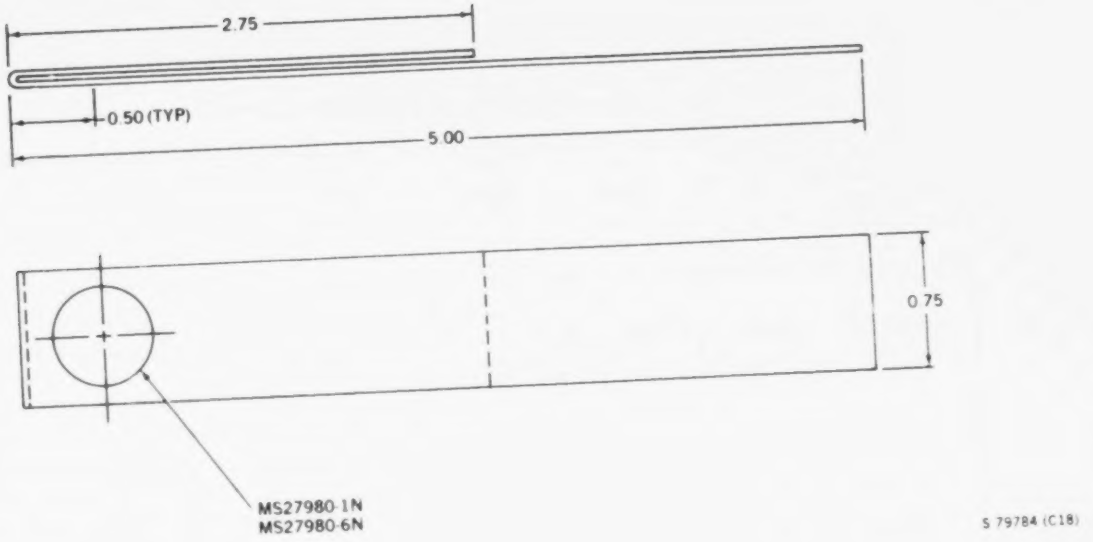
DASH NO.	LENGTH L
-109	5.06
-121	10.00

NOTES:

1. MAKE FROM 0.750-INCH-WIDE GRAY NYLON WEBBING, TYPE 1A, MIL-W-4088, NSN 5340-01-097-5199.
2. ALL DIMENSIONS ARE IN INCHES.
3. CUT WEBBING TO REQUIRED SIZE AND INSTALL MS27980-1N, NSN 5325-00-276-4953, AND MS27980-6N, NSN 5325-00-276-4946, SNAP FASTENER PER TM 55-1500-204-25/1.
4. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 70500-02068-109, -121 SIDE WALL PANEL STRAP.

FIGURE H-126. STRAP

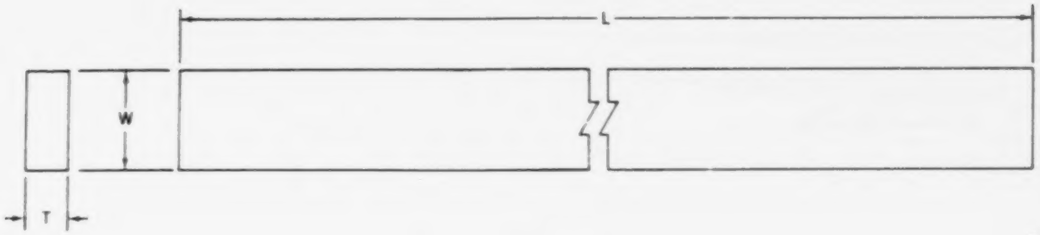

2.75
0.50 (TYP)
5.00
0.75
MS27980-1N
MS27980-6N
S 79784 (C18)

NOTES:

1. MAKE FROM 0.750-INCH-WIDE GRAY NYLON WEBBING, TYPE 1A, MIL-W-4088, NSN 5340-01-097-5199.
2. ALL DIMENSIONS ARE IN INCHES.
3. CUT WEBBING TO 7.75-INCH LENGTH AND FOLD AS SHOWN.
4. INSTALL MS27980-1N, NSN 5325-00-276-4953, AND MS27980-6N, NSN 5325-00-276-4946, SNAP FASTENER PER TM 55-1500-204-25/1.
5. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 70500-02068-124 SIDE WALL PANEL STRAP.

FIGURE H-127. STRAP



NOMENCLATURE	T THICKNESS	W WIDTH	L LENGTH	SIKORSKY PART NUMBER
ENGINE AIR INLET SEALS	0.050	1.50	20.0	70302-10019-101
			15.0	70302-10019-102
			28.0	70302-10019-103
			26.0	70302-10019-104
			3.0	70302-10019-105

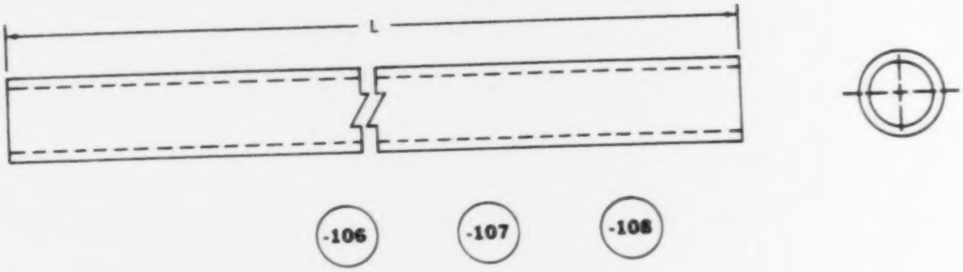
NOTES:

1. MAKE FROM 0.050-INCH-THICK RUBBER, TYPE 2, CLASS 1, MIL-R-83248, FSCM 81349.
2. ALL DIMENSIONS ARE IN INCHES.
3. CUT SEALS TO LENGTH PER CHART.
4. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER
1986
THIRD QUARTER

PART NUMBER: 70302-10019-101, -102, -103, -104, -105 ENGINE AIR INLET SEALS.

FIGURE H-128. ENDING AIR INLET SEAL



S 79786 (C18)

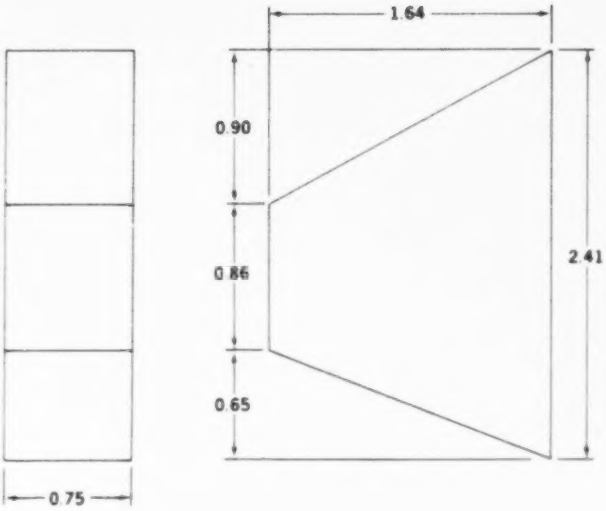
DASH NO.	LENGTH L
-106	38.00
-107	44.00
-108	56.00

NOTES:

1. MAKE FROM 0.750 OD x 0.625 ID COMMERCIAL URETHANE TUBING (TYGOTHANE), NSN 4720-01-176-6328.
2. ALL DIMENSIONS ARE IN INCHES.
3. CUT TUBING TO LENGTH PER CHART.
4. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 70500-02073-106, -107, -108 DRIP PAN DRAIN TUBES.

FIGURE H-129. DRAIN TUBE



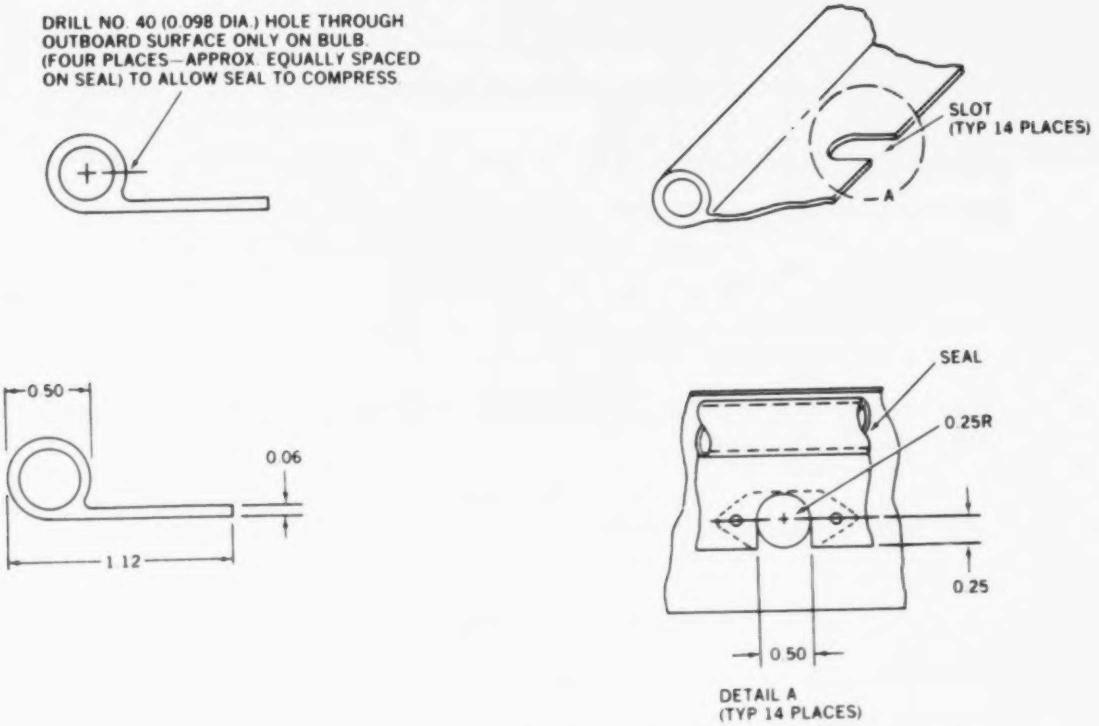
S 79787 (C18)

NOTES:
1. MAKE FROM 0.75-INCH-THICK RUBBER, TYPE 2, GRADE A MEDIUM, MIL-R-6130, FSCM 81349.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: $\underbrace{\text{P/N 70216-02401-107}}_{\text{PART NUMBER}}$ $\underbrace{\text{3Q}}_{\text{THIRD QUARTER}}$ $\underbrace{\text{86}}_{\text{1986}}$

PART NUMBER: 70302-02142-110 ENGINE FAIRING SEAL.

FIGURE H-130. ENGINE FAIRING SEAL


DRILL NO. 40 (0.098 DIA.) HOLE THROUGH OUTBOARD SURFACE ONLY ON BULB. (FOUR PLACES—APPROX. EQUALLY SPACED ON SEAL) TO ALLOW SEAL TO COMPRESS.
SLOT (TYP 14 PLACES)
A
0.50
0.06
1.12
SEAL
0.25R
0.25
0.50
DETAIL A (TYP 14 PLACES)

S 79788 (C18)

NOTES:

1. MAKE SEAL FROM NO. 7511 SILICONE RUBBER EXTRUSION, FSCM 11960.
2. ALL DIMENSIONS ARE IN INCHES.
3. APPROXIMATE LENGTH OF SEAL IS 120 INCHES. TRIM TO FIT ON INSTALLATION. FLAT PORTION OF SEAL MAY BE SLIT, AS REQUIRED, TO ALLOW EASE OF FORMING CORNER RADII.
4. PICK UP SLOT LOCATION ON INSTALLATION AND CUT SLOTS PER DETAIL A.
5. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE YELLOW INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

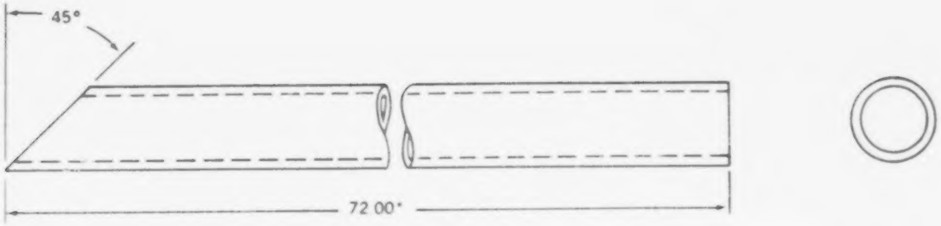
EXAMPLE: P/N 70216-02401-107 3Q 86

PART NUMBER 1986

THIRD QUARTER

PART NUMBER: 70500-02070-108 DRIP PAN SEAL.

FIGURE H-131. DRAIN PAN SEAL



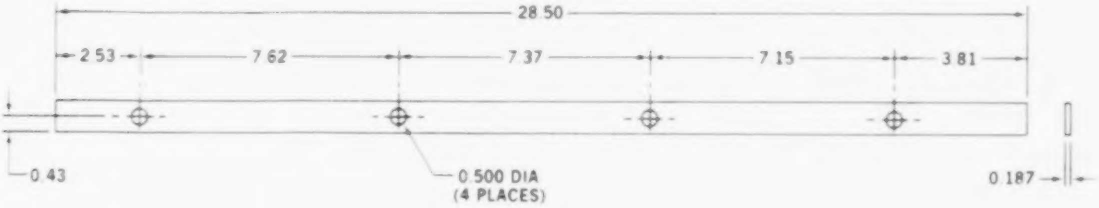
*OVERSIZE—TRIM ON INSTALLATION

S 79792 (C18)

NOTES:
1. MAKE FROM 0.750 OD x 0.625 ID URETHANE TUBING (TYGOTHANE), NSN 4720-01-176-6328.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 70500-02076-101 DRAIN TUBE

FIGURE H-132. DRAIN TUBE



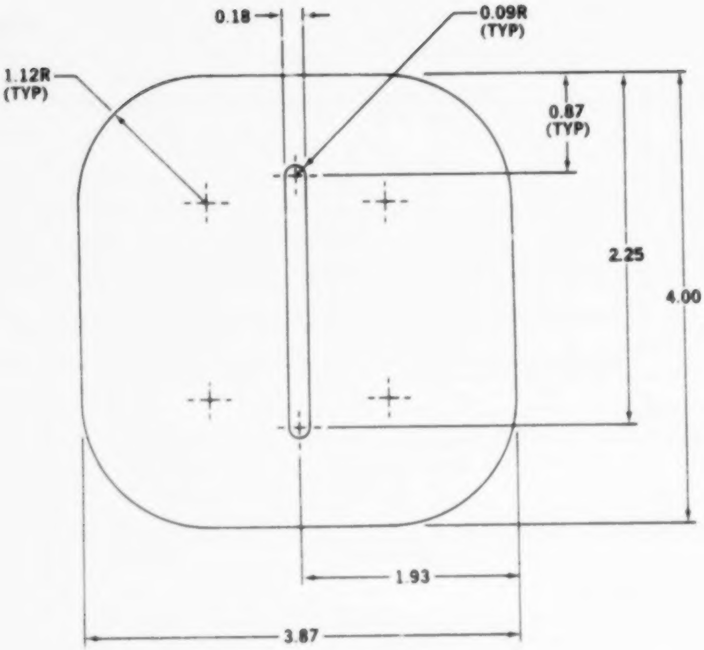
S 79794 (C18)

NOTES:
1. MAKE FROM 0.187-INCH-THICK SCE-3L RUBBER, MIL-C-3133, NSN 9320-00-815-9734.
2. ALL DIMENSIONS ARE IN INCHES.
3. PUNCH FOUR 0.500-INCH-DIAMETER HOLES IN SEAL, AS SHOWN IN FIGURE.
4. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70500-02072-109 CEILING PANEL SEAL

FIGURE H-133. CEILING PANEL SEAL



S 79796 (C18)

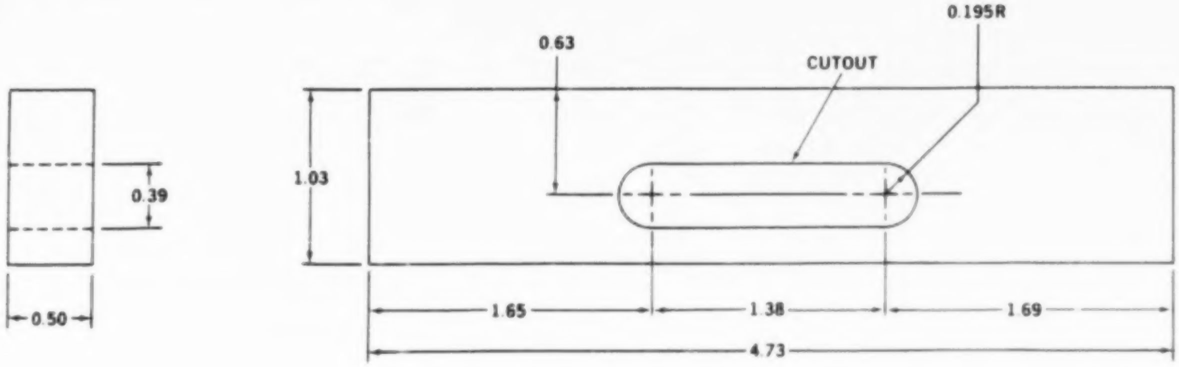
NOTES:

1. MAKE FROM 0.125-INCH-THICK SCE-3L RUBBER, MIL-STD-670, NSN 9320-01-154-2225.
2. ALL DIMENSIONS ARE IN INCHES.
3. CUT SLOT IN SEAL AS SHOWN.
4. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70500-02072-110 CEILING PANEL SEAL.

FIGURE H-134. SEAL



S 79798 (C18)

NOTES:

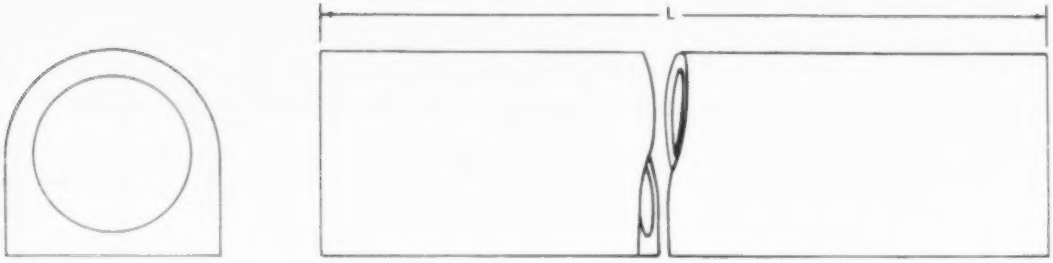
1. MAKE FROM 0.50-INCH-THICK, TYPE 1, GRADE C SOFT RUBBER, MIL-R-6130, NSN 9320-00-848-7302.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107   3Q 86
PART NUMBER   1986
THIRD QUARTER

4. TRIM SEAL TO FIT, AS REQUIRED.

PART NUMBER: 70217-02721-110 CARGO DOOR SEAL.

FIGURE H-135. CARGO DOOR SEAL



S 79799 (C18)

NOMENCLATURE	L LENGTH	SIKORSKY PART NUMBER
CARGO DOOR SEALS	37.19 16.11	70217-02721-116 70217-02721-117

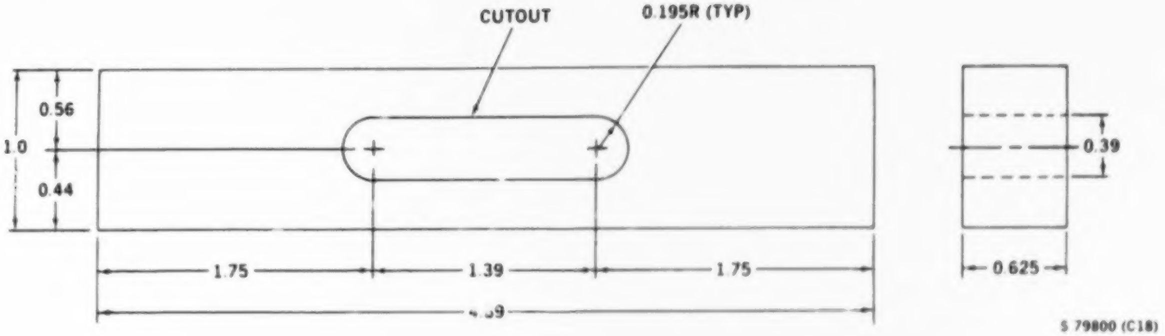
NOTES:

1. MAKE FROM EXTRUDED RUBBER, MUELLER DIE NO. 5629, NSN 1560-01-177-5120.
2. REMOVE FLANGE OF SEAL. FINAL CROSS SECTION OF SEAL SHALL BE AS SHOWN IN FIGURE.
3. ALL DIMENSIONS ARE IN INCHES.
4. CUT SEAL MATERIAL TO LENGTH PER CHART.
5. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER
1986
THIRD QUARTER

PART NUMBER: 70217-02721-116, -117 CARGO DOOR SEALS.

FIGURE H-136. CARGO DOOR SEAL


CUTOUT
0.195R (TYP)
0.56
1.0
0.44
1.75
1.39
1.75
0.39
0.625
S 79800 (C18)

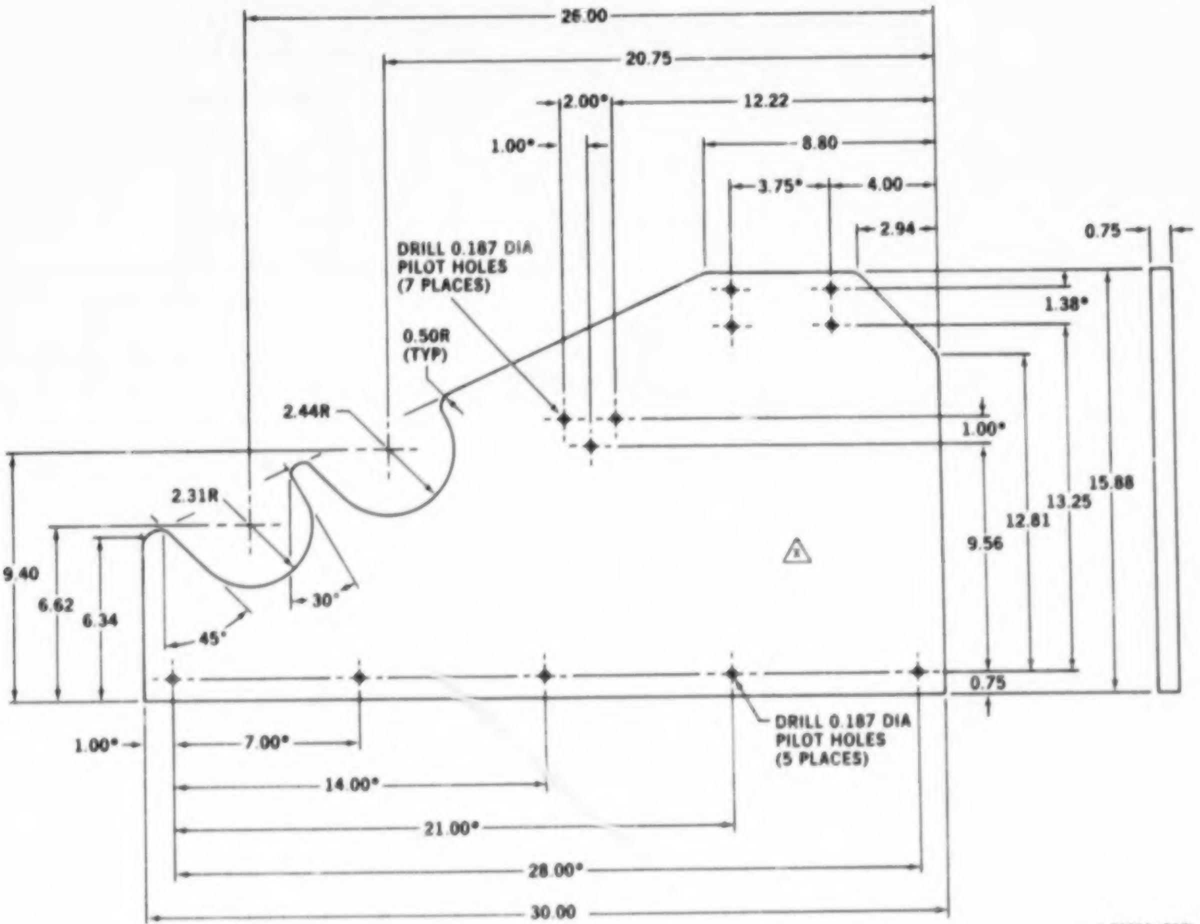
NOTES:

1. MAKE FROM 0.625-INCH-THICK SOFT RUBBER, TYPE 1, GRADE C, MIL-R-6130, FSCM 81349.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70217-02721-132 CARGO DOOR SEAL.

FIGURE H-137. CARGO DOOR SEAL

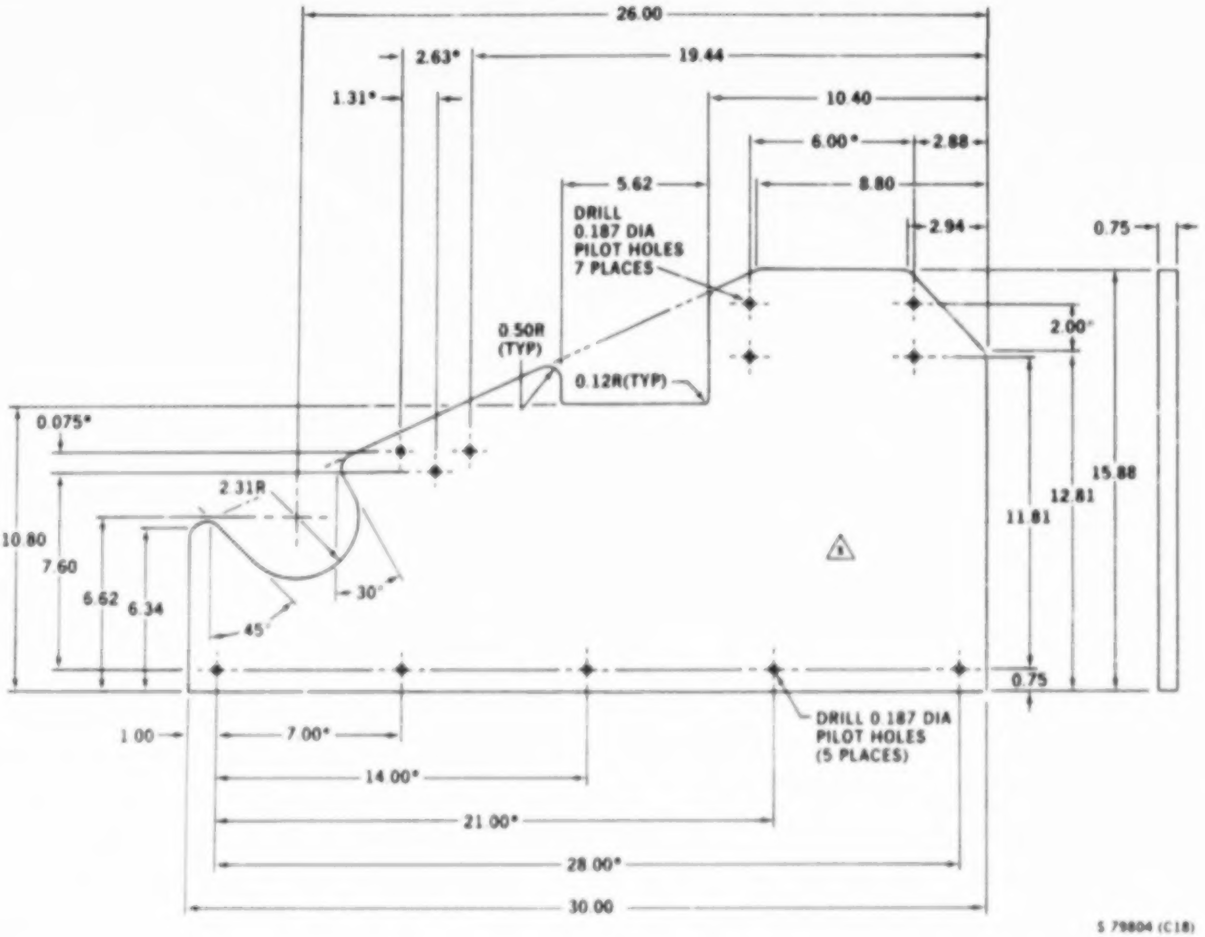

26.00
20.75
2.00*
12.22
1.00*
8.80
3.75*
4.00
2.94
0.75
DRILL 0.187 DIA
PILOT HOLES
(7 PLACES)
0.50R
(TYP)
1.38*
2.44R
1.00*
2.31R
X
15.88
13.25
12.81
9.56
9.40
6.62
6.34
30°
45°
0.75
1.00*
7.00*
DRILL 0.187 DIA
PILOT HOLES
(5 PLACES)
14.00*
21.00*
28.00*
30.00

S 79803 (C18)

NOTES:
1. MAKE FROM 0.75-INCH-THICK EXTERIOR GRADE PLYWOOD, A-A-1417, NSN 5530-00-051-0512.
2. ALL DIMENSIONS ARE IN INCHES.
3. DIMENSIONS MARKED WITH ASTERISK (*) ARE BASIC DIMENSIONS AND SHOULD BE HELD TO ±0.03 INCH.
4. DRILL 0.187-INCH-DIAMETER PILOT HOLES AS SHOWN IN FIGURE. HOLES ARE TO BE OPENED TO 0.312-INCH DIAMETER ON ASSEMBLY.
5. FINISH: 1 COAT RK147 VARNISH, FSCM 81439.
   1 COAT EPOXY PRIMER, MIL-P-23377, NSN 8010-00-082-2477.
   2 COATS POLYURETHANE, MIL-C-81773, YELLOW PER FED. STD 595, NSN 8010-00-181-8208.
6. MARK PARTS PER MIL-STD-130 IN LOCATION SHOWN BY △X IN F/D.

PART NUMBER: 70700-20313-104 STORAGE FRAME.

FIGURE H-138. PLYWOOD FRAME

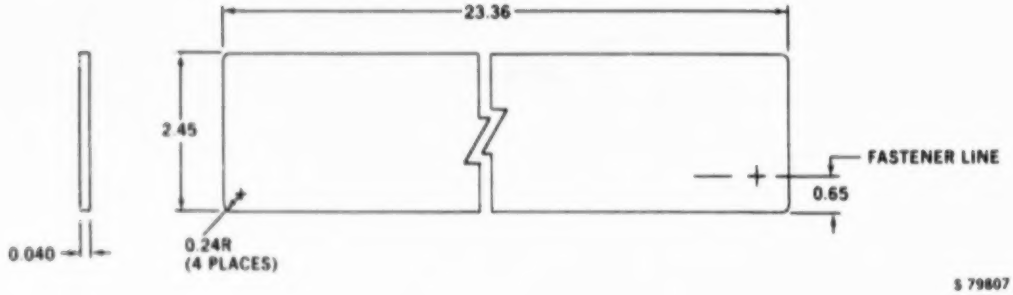

26.00
2.63*
19.44
1.31*
10.40
6.00*
2.88
5.62
8.80
DRILL
0.187 DIA
PILOT HOLES
7 PLACES
2.94
0.75
0.50R
(TYP)
0.12R(TYP)
2.00*
0.075*
15.88
12.81
11.81
2.31R
10.80
7.60
6.62
6.34
30°
45°
0.75
1.00
7.00*
DRILL 0.187 DIA
PILOT HOLES
(5 PLACES)
14.00*
21.00*
28.00*
30.00
S 79804 (C18)

NOTES:

1. MAKE FROM 0.75-INCH-THICK EXTERIOR GRADE PLYWOOD, A-A-1417, NSN 5530-00-051-0512.
2. ALL DIMENSIONS ARE IN INCHES.
3. DIMENSIONS MARKED WITH ASTERISK (*) ARE BASIC DIMENSIONS AND SHOULD BE HELD TO ±0.03 INCH.
4. DRILL 0.187-INCH-DIAMETER PILOT HOLES AS SHOWN IN FIGURE. HOLES ARE TO BE OPENED TO 0.312-INCH DIAMETER ON ASSEMBLY.
5. FINISH: 1 COAT RK147 VARNISH, FSCM 81439.
   1 COAT EPOXY PRIMER, MIL-P-23377, NSN 8010-00-082-2477.
   2 COATS POLYURETHANE, MIL-C-81773, YELLOW PER FED. STD 595, NSN 8010-00-181-8208.
6. MARK PARTS PER MIL-STD-130 IN LOCATION SHOWN BY △x IN F/D.

PART NUMBER: 70700-20313-105 STORAGE FRAME.

FIGURE H-139. PLYWOOD FRAME

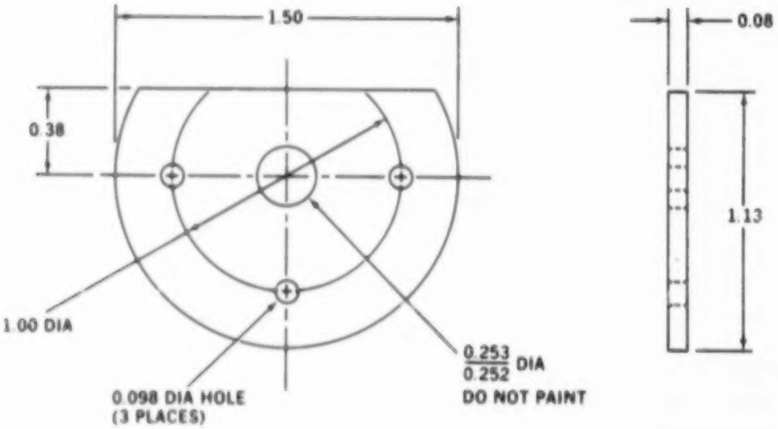

23.36
2.45
FASTENER LINE
0.65
0.040
0.24R
(4 PLACES)
S 79807 (C18)

NOTES:

1. MAKE FROM 0.040-INCH-THICK NYLATRON G.S., L-P-410A, NSN 9330-00-602-5921.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 70217-02721-140 CARGO DOOR SEAL.

FIGURE H-140. CARGO DOOR SEAL

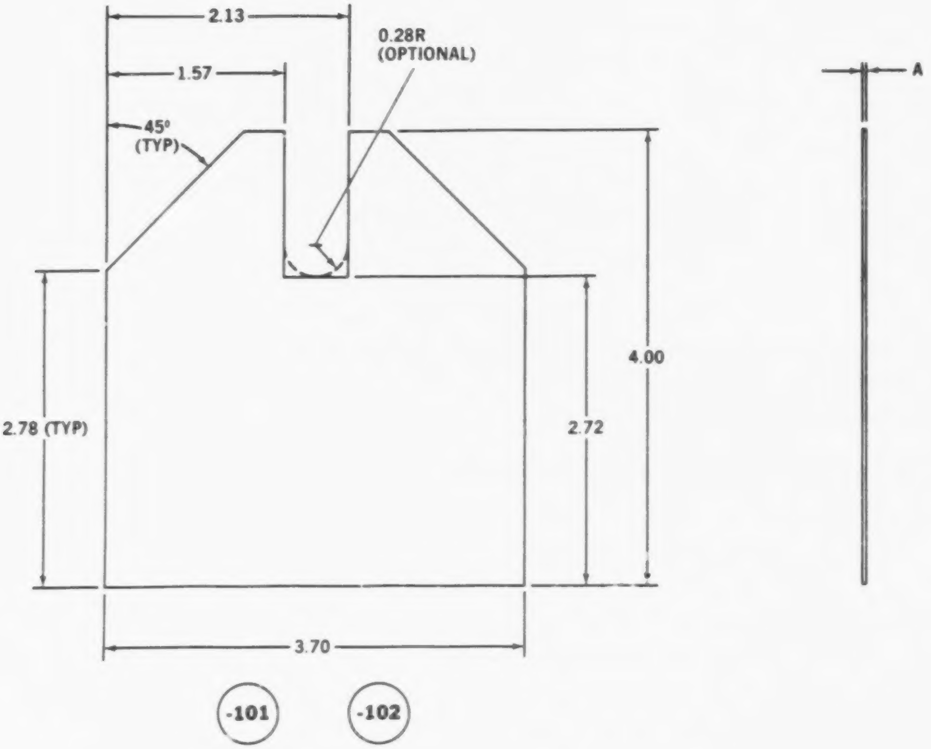

1.50
0.08
0.38
1.13
1.00 DIA
0.098 DIA HOLE
(3 PLACES)
0.253
0.252 DIA
DO NOT PAINT
S 79810 (C18)

NOTES:

1. MAKE FROM 0.080-INCH-THICK 7075-T6 ALCLAD ALUMINUM SHEET, QQ-A-250/13, NSN 9535-00-232-7542.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 70217-01000-114 DOUBLER.

FIGURE H-141. DOUBLER


2.13
1.57
0.28R
(OPTIONAL)
45°
(TYP)
A
4.00
2.78 (TYP)
2.72
3.70
-101
-102

S 79812 (C18)

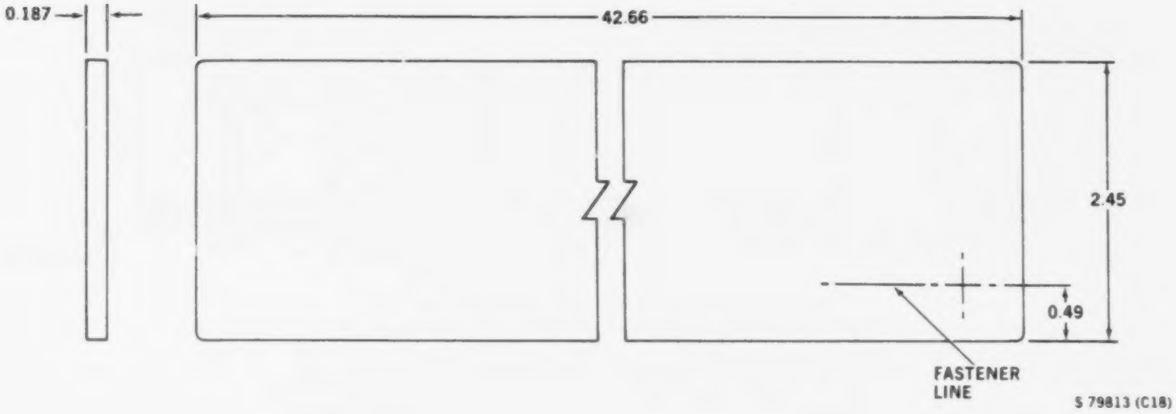
DASH NO.	DIMENSION A
-101	0.004
-102	0.005

NOTES:

1. MAKE FROM 302 STAINLESS STEEL, MIL-S-5059, FSCM 81349 USING THICKNESS LISTED IN CHART.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-130.
4. THIS IS CHECKING SHIM ONLY AND MUST BE REMOVED FROM ACFT AFTER TAIL ROTOR INSTALLATION IS COMPLETED.

PART NUMBER: 70102-11109-101, -102 TAIL ROTOR INSTALLATION CHECKING SHIM.

FIGURE H-142. CHECKING SHIM



NOTES:

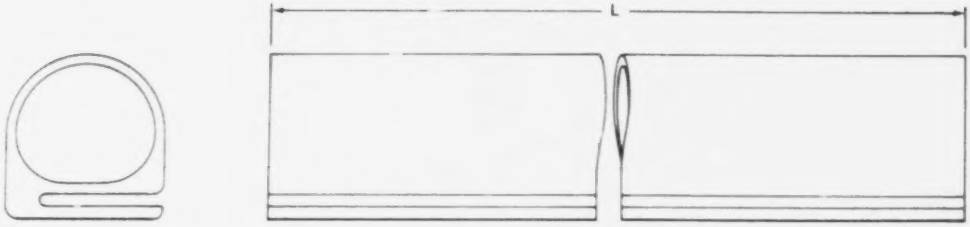
1. MAKE FROM 0.187-INCH-THICK RUBBER, SCE-11L, MIL-STD-670, FSCM 81349.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER
1986
THIRD QUARTER

4. PICK UP FASTENER HOLES ON INSTALLATION.

PART NUMBER: 70217-02721-141 CARGO DOOR SEAL.

FIGURE H-143. CARGO DOOR SEAL



S 79815 (C18)

SIKORSKY PART NUMBER	LENGTH L
70217-02721-147 70217-02721-148	36.88 17.21

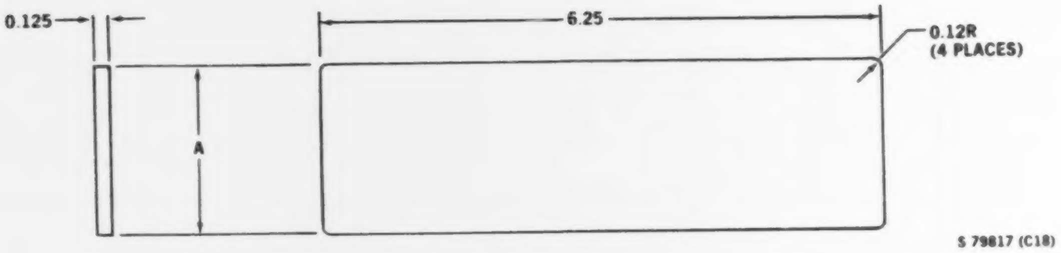
NOTES:

1. MAKE FROM EXTRUDED RUBBER SEAL, DIE NO. 8487, NSN 5330-01-179-9496.
2. ALL DIMENSIONS ARE IN INCHES.
3. CUT SEALS TO LENGTH PER CHART.
4. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70217-02721-147, -148 CARGO DOOR SEALS.

FIGURE H-144. CARGO DOOR SEAL


0.125
6.25
0.12R
(4 PLACES)
A
S 79817 (C18)

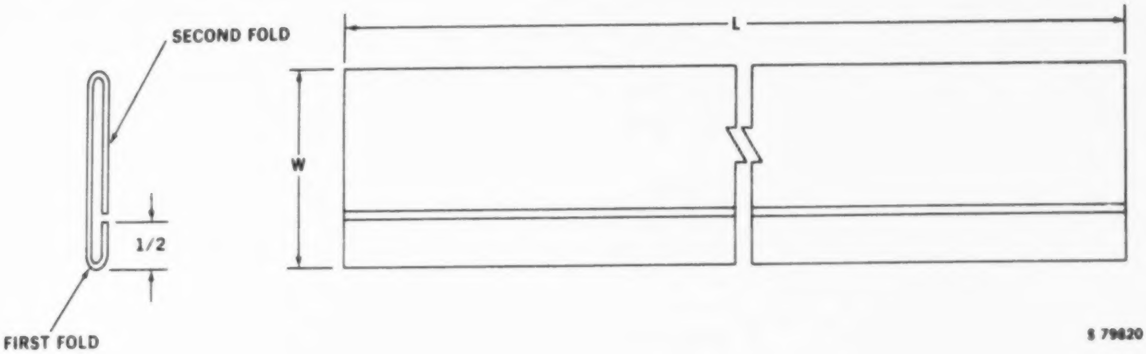
DASH NO.	DIMENSION A
-102	1.38
-103	2.00

NOTES:

1. MAKE FROM 0.125-INCH-THICK 2024-T351 ALUMINUM ALLOY QQ-A-250/5, NSN 9535-00-232-0418.
2. ALL DIMENSIONS ARE IN INCHES.
3. CUT WIDTH OF WEAR STRIPS PER CHART.
4. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 70700-20677-102, -103 WEAR STRIPS.

FIGURE H-145. WEAR STRIP



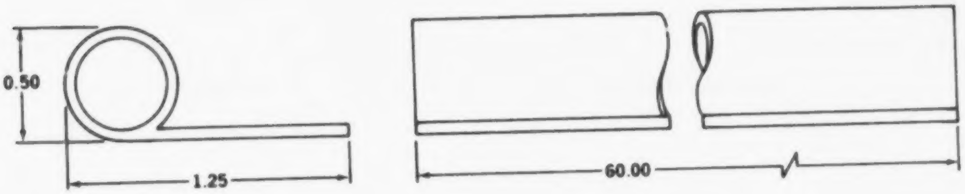
NOMENCLATURE	WIDTH	LENGTH	SIKORSKY PART NUMBER
CONTROLS ENCLOSURE FLAP	4.25	58.50	70500-02053-117
CONTROLS ENCLOSURE FLAP	4.25	50.00	70500-02053-118

NOTES:

1. MAKE FROM SS9232-024 PLASTIC SHEET, NSN 9330-01-115-7085.
2. FOLD ENDS 0.50 INCH AND SEW PER FED. STD 751. USE THREAD, V-T-295, NSN 8310-00-559-5212.
3. FOLD FLAP LENGTHWISE TO 0.50 INCH AND SEW PER FED. STD 751. USE THREAD, V-T-295, NSN 8310-00-559-5212.
4. MAKE SECOND LENGTHWISE FOLD TO BUTT AGAINST FIRST FOLD AND SEW PER FED. STD 751. USE THREAD, V-T-295, NSN 8310-00-559-5212.
5. ALL DIMENSIONS ARE IN INCHES.
6. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 70500-02053-117, -118 CONTROLS ENCLOSURE FLAP.

FIGURE H-146. CONTROLS ENCLOSURE FLAP

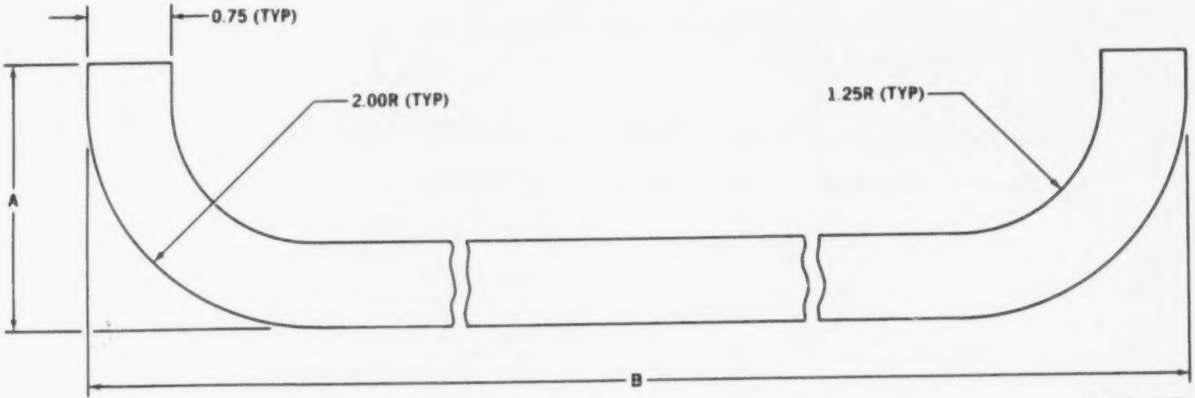


S 79821 (C18)

NOTES:
1. MAKE FROM BULK SEAL, DIE NO. JM151-18A, FSCM 75165.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 70308-03010-105 EXHAUST FAIRING BULKHEAD SEAL.

FIGURE H-147. EXHAUST FAIRING BULKHEAD SEAL



S 79822 (C18)

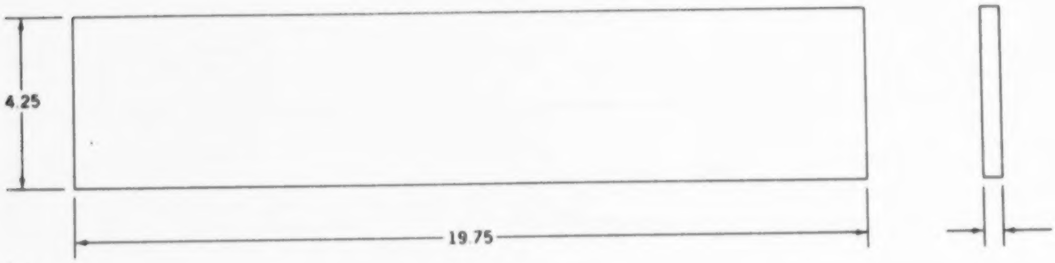
DASH NO.	DIMENSION A	DIMENSION B
-155	2.50	28.00
-160	2.37	28.00

NOTES:
1. MAKE FROM 0.125-INCH-THICK FOAM RUBBER SHEET, SCE-11L, MIL-STD-670, NSN 9320-01-154-2225.
2. USE TWO PIECES TO MAKE .125.
3. ALL DIMENSIONS ARE IN INCHES.
4. CUT GASKET TOPS TO SIZE PER CHART.
5. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70500-02059-155, -160 GASKET TOP.

FIGURE H-148. GASKET TOP



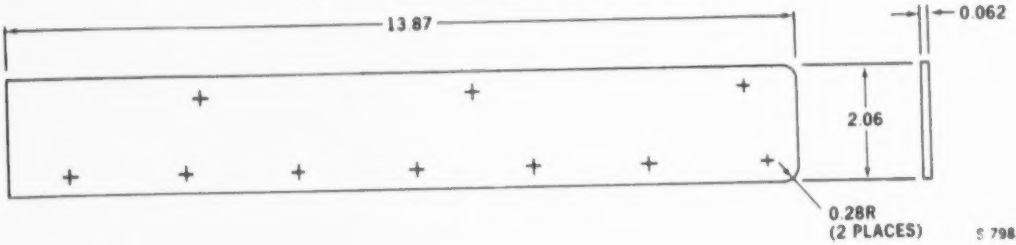
S 79823 (C18)

NOTES:
1. MAKE FROM 0.375-INCH-THICK RUBBER, TYPE 2, GRADE A MEDIUM, MIL-R-6130, NSN 5330-00-232-2420.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER
1986
THIRD QUARTER

PART NUMBER: 70700-20426-118 TAIL ROTOR ADAPTER PAD.

FIGURE H-149. TAIL ROTOR ADAPTER PAD



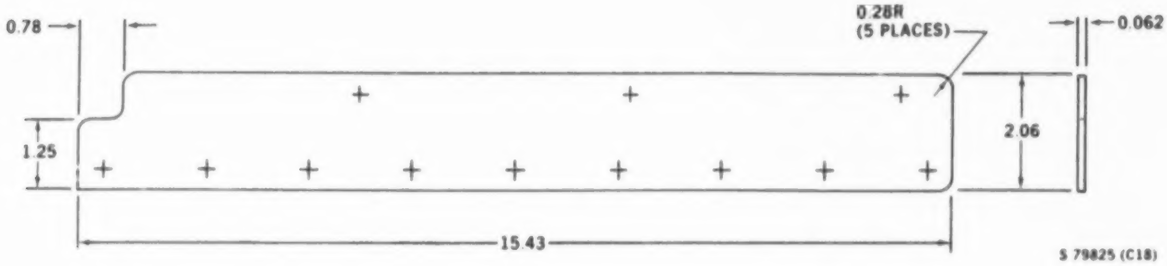
S 79824 (C18)

NOTES:
1. MAKE FROM 0.062-INCH-THICK, NITRILE RUBBER SHEET, CLASS 1, GRADE 60 PER MIL-R-6855, NSN 9320-00-241-9742.
2. ALL DIMENSIONS ARE IN INCHES.
3. PICK UP EXISTING FASTENER PATTERN ON INSTALLATION.
4. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE YELLOW INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER
1986
THIRD QUARTER

PART NUMBER: 70500-02060-145 DRIP PAN SEAL, STATION 327-360.

FIGURE H-150. SEAL



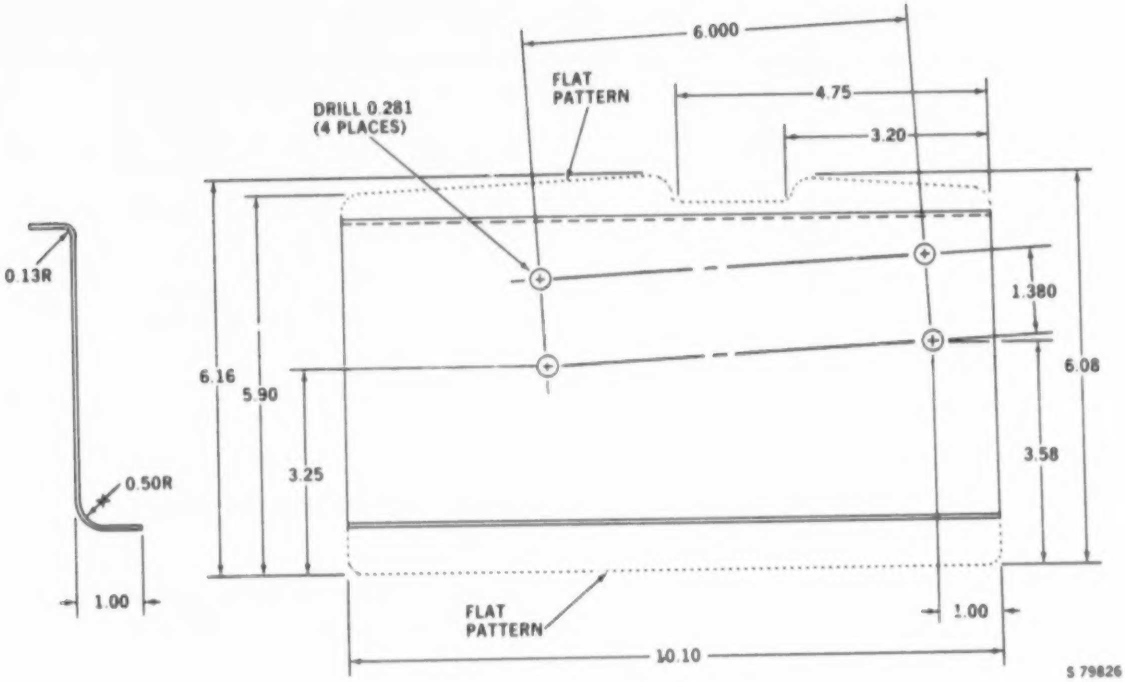
NOTES:

1. MAKE FROM 0.062-INCH-THICK NITRILE RUBBER SHEET, CLASS 1, GRADE 60 PER MIL-R-6855, NSN 9320-01-241-9742.
2. ALL DIMENSIONS ARE IN INCHES.
3. PICK UP EXISTING FASTENER PATTERN ON INSTALLATION.
4. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE YELLOW INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70500-02060-143 DRIP PAN SEAL.

FIGURE H-151. SEAL

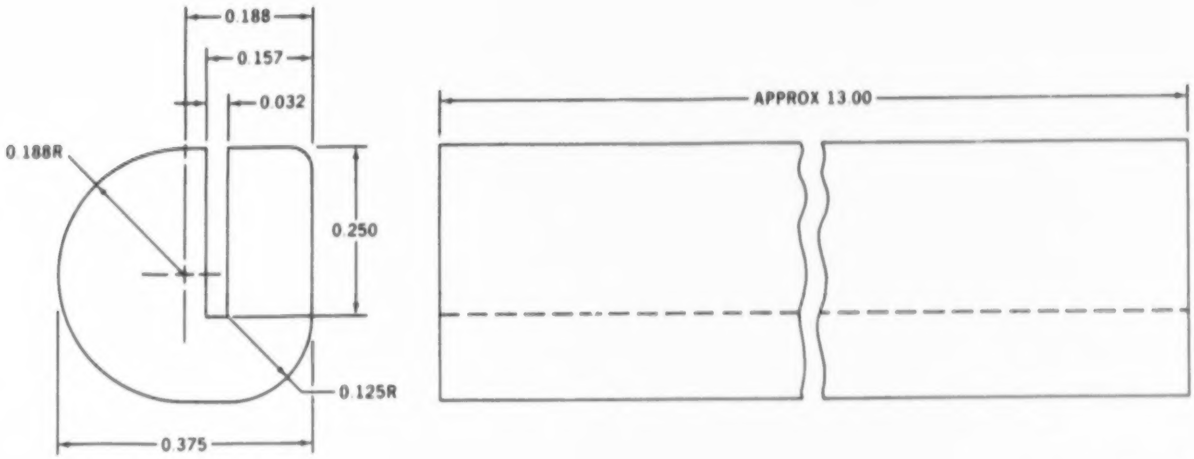

6.000
4.75
3.20
FLAT PATTERN
DRILL 0.281 (4 PLACES)
0.13R
1.380
6.16
5.90
3.25
6.08
3.58
0.50R
1.00
FLAT PATTERN
1.00
10.10

S 79826 (C18)

NOTES:
1. MAKE FROM 0.040-INCH-THICK ALUMINUM SHEET, 7075-0, QQ-A-250/13, NSN 9535-00-084-4581.
2. ROUND ALL EXTERNAL CORNERS TO 0.280-INCH RADIUS, AND ALL INTERNAL CORNERS TO 0.16-INCH RADIUS.
3. ALL DIMENSIONS ARE IN INCHES.
4. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 70500-02053-116 CONTROLS ENCLOSURE SUPPORT.

FIGURE H-152. CONTROLS ENCLOSURE SUPPORT



S 79827 (C18)

NOTES:

1. MAKE FROM SS2929-120 MOULDED SYNTHETIC CELLULAR SPONGE EDGING, MIL-R-6130, FSCM 78286.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GRAY INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

4. TRIM TO FIT ON INSTALLATION.

PART NUMBER: 70500-02058-167 SIDEWALL DUCT SEAL.

FIGURE H-153. SIDE WALL DUCT SEAL

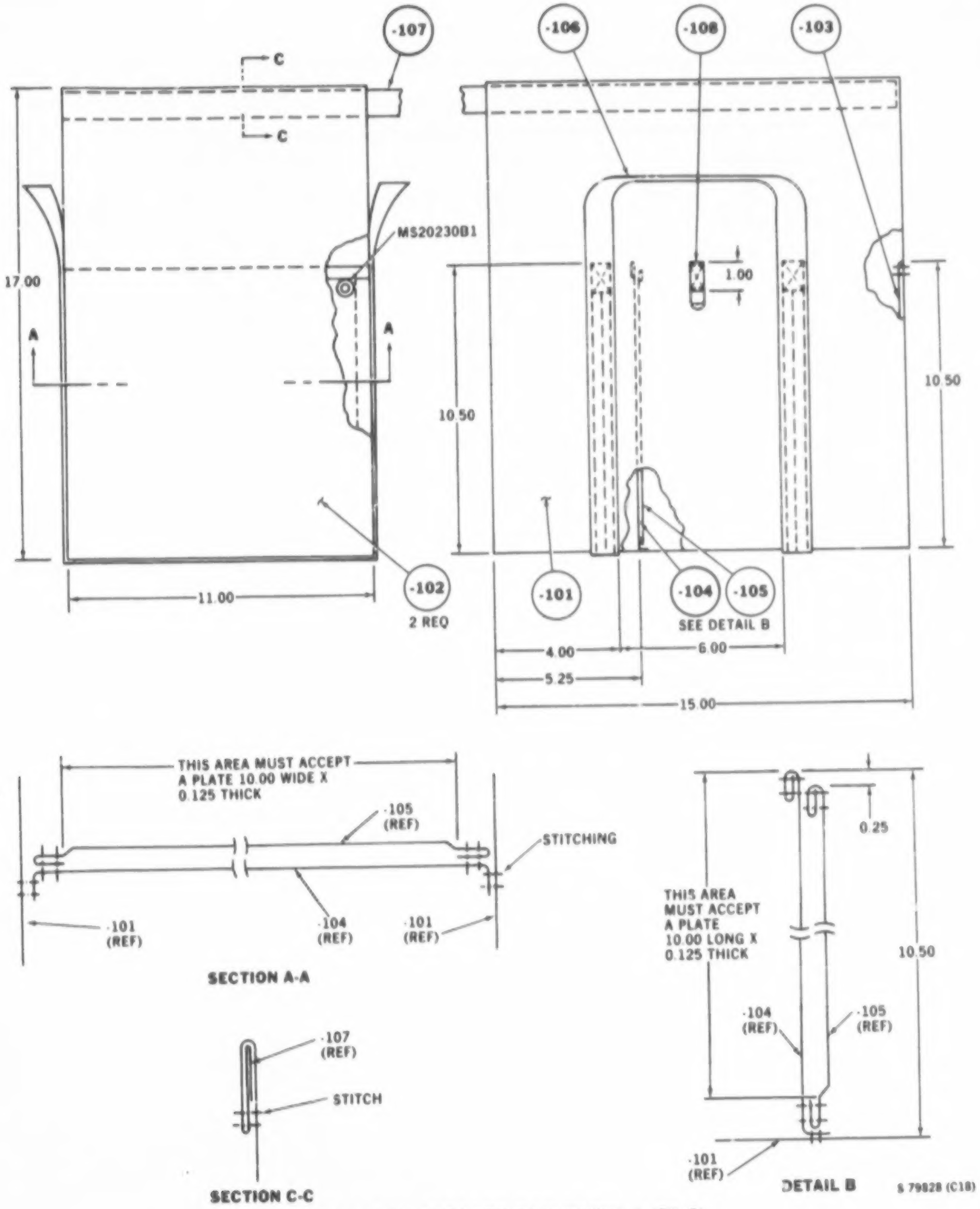

-107
-106
-108
-103
C
C
MS20230B1
17.00
A
A
1.00
10.50
10.50
-102
2 REQ
11.00
-101
-104
-105
SEE DETAIL B
4.00
6.00
5.25
15.00
THIS AREA MUST ACCEPT A PLATE 10.00 WIDE X 0.125 THICK
-105 (REF)
STITCHING
-101 (REF)
-104 (REF)
-101 (REF)
SECTION A-A
-107 (REF)
STITCH
SECTION C-C
0.25
THIS AREA MUST ACCEPT A PLATE 10.00 LONG X 0.125 THICK
10.50
-104 (REF)
-105 (REF)
-101 (REF)
DETAIL B
S 79828 (C18)

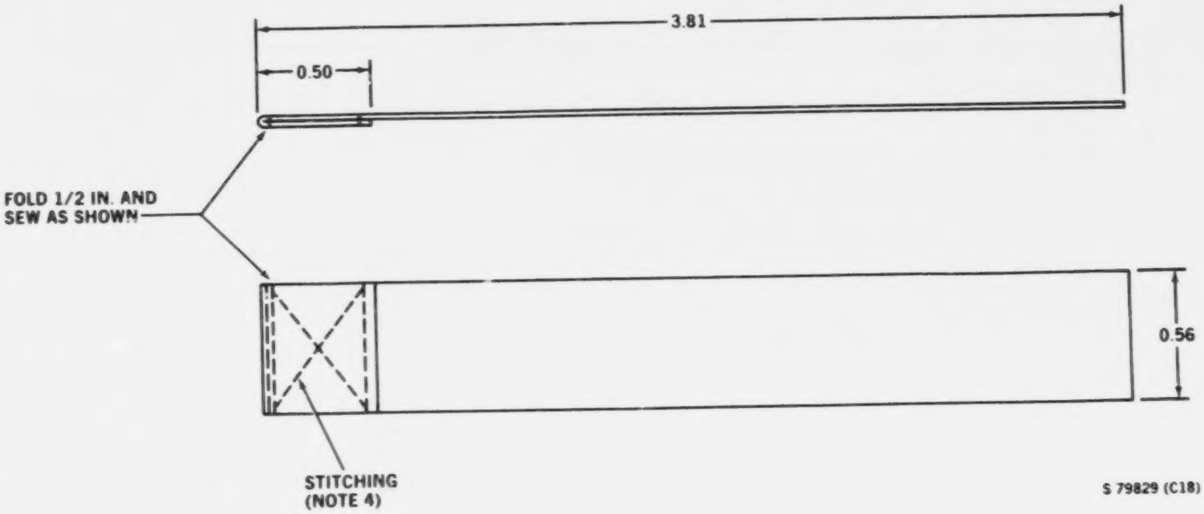
FIGURE H-154. STORAGE BAG (SHEET 1 OF 2)

PART NUMBER	QTY	NOMENCLATURE	MATERIAL AND SPECIFICATION
70700-20325-101	1	PANEL	SEE NOTES 1, 6, 8
70700-20325-102	2	END PANEL	SEE NOTES 1, 6, 8
70700-20325-103	1	REINFORCEMENT	SEE NOTES 1, 6
70700-20325-104	1	PANEL	SEE NOTES 1, 6
70700-20325-105	1	POCKET	SEE NOTES 1, 6
70700-20325-106	1	STRAP	SEE NOTES 2, 6
70700-20325-107	1	TIE	SEE NOTES 3, 6
70700-20325-108	1	TAPE	SEE NOTES 4, 6
MS20230B1	1	GROMMET	SEE NOTE 7
V-T-276	FT	THREAD	SEE NOTES 6, 8

NOTES:

1. MAKE 70700-20325-101, -102, -103, -104, -105 FROM 10-OUNCE COTTON DUCK, COLOR OLIVE DRAB. NSN 8305-00-170-3449.
2. MAKE 70700-20325-106, FROM 1.00 INCH WIDE x 94.00 INCH LONG COTTON WEBBING, TYPE I, MIL-W-5665, COLOR OLIVE DRAB. NSN 8305-00-281-3315.
3. MAKE 70700-20325-107 FROM 1.00 INCH WIDE x 60.00 INCH LONG COTTON WEBBING, TYPE I, MIL-W-5665, COLOR, OLIVE DRAB. NSN 8305-00-281-3315.
4. MAKE 70700-20325-108 FROM 0.562 INCH WIDE x 0.04-0.05 INCH THICK COTTON WEBBING TYPE I, COLOR, OLIVE DRAB. NSN 8305-00-753-6341.
5. ALL FOLDS BEFORE SEWING TO BE AT LEAST 0.50 INCH.
6. ALL SEWING TO BE PER FED. STD 751 USING THREAD, V-T-276, TICKET NO. 16, 4 PLY COTTON. COLOR, OLIVE DRAB. NSN 8310-00-262-2551.
7. INSTALL GROMMET, NSN 5325-00-291-0275, ON REINFORCEMENT AS SHOWN IN FIGURE PER MIL-S-8512.
8. SEW PANEL AND END PANELS ON WRONG SIDE AND REVERSE FOR END PRODUCT.

FIGURE H-154. STORAGE BAG (SHEET 2 OF 2)


3.81
0.50
FOLD 1/2 IN. AND SEW AS SHOWN
0.56
STITCHING (NOTE 4)
S 79829 (C18)

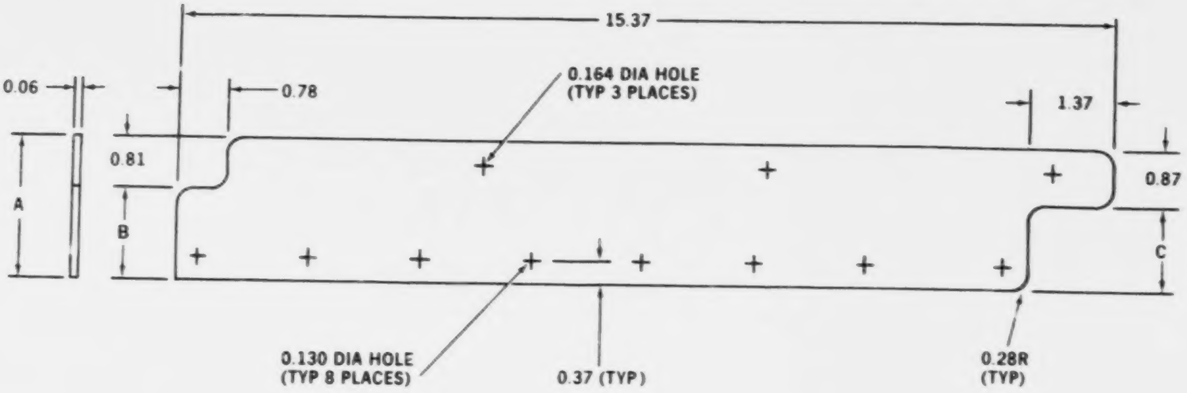
NOTES:

1. MAKE FROM 0.562-INCH-WIDE NYLON WEBBING, TYPE 1A, MIL-W-4088, COLOR GRAY (FSCM 81349).
2. CUT LENGTH TO 4.312 INCHES.
3. ALL DIMENSIONS ARE IN INCHES.
4. FOLD AND SEW TAB AS SHOWN IN FIGURE. STITCHING TO BE PER FED. STD 751, USING V-T-295 NYLON THREAD, COLOR GRAY, NSN 9320-00-202-1935.
5. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 70500-03050-130 BLANKET ASSEMBLY TAB.

FIGURE H-155. BLANKET ASSEMBLY TAB

best copy available


15.37
0.06
0.78
0.164 DIA HOLE (TYP 3 PLACES)
1.37
0.81
0.87
A
B
C
0.130 DIA HOLE (TYP 8 PLACES)
0.37 (TYP)
0.28R (TYP)

S 79830 (C18)

SIKORSKY PART NUMBER	DIMENSION A	DIMENSION B	DIMENSION C
70500-02060-192	2.05	1.24	1.18
70500-02060-207	2.23	1.42	1.36

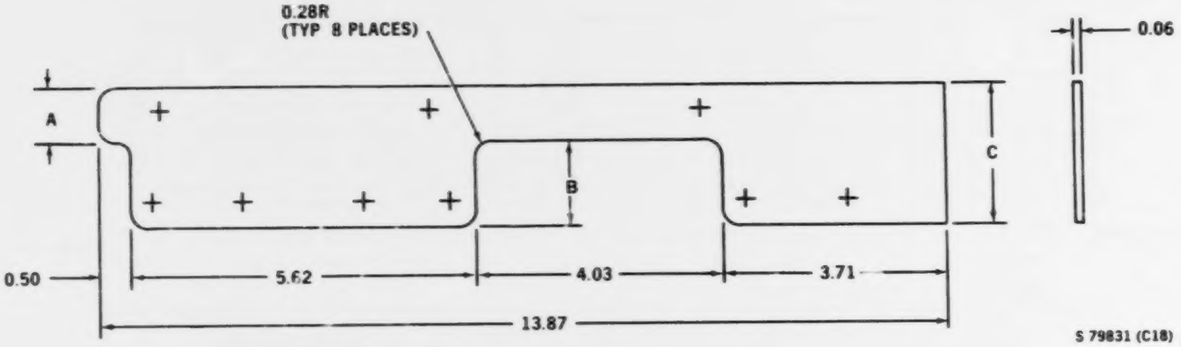
NOTES:

1. MAKE FROM 0.062-INCH-THICK NITRILE RUBBER SHEET, CLASS 1, GRADE 60, MIL-R-6855, NSN 9320-00-241-9742.
2. ALL DIMENSIONS ARE IN INCHES.
3. MAKE SEALS PER FIGURE AND DIMENSIONS IN CHART.
4. FASTENER HOLES ARE PICKED UP ON ASSEMBLY.
5. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE YELLOW INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER
1986
THIRD QUARTER

PART NUMBER: 70500-02060-192, -207 DRIP PAN INSTALLATION SEAL.

FIGURE H-156. DRIP PAN SEAL



SIKORSKY PART NUMBER	DIMENSION A	DIMENSION B	DIMENSION C
70500-02060-193	0.88	1.17	2.05
70500-02060-208	0.88	1.35	2.23

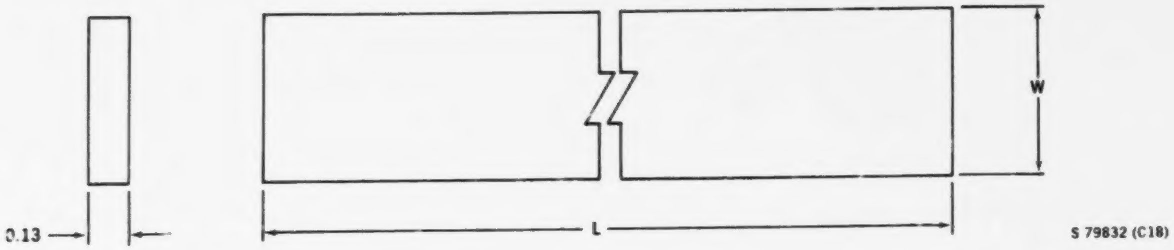
NOTES:

1. MAKE FROM 0.062-INCH-THICK NITRILE RUBBER SHEET, CLASS 1, GRADE 60, MIL-R-6855, NSN 9320-00-241-9742.
2. ALL DIMENSIONS ARE IN INCHES.
3. MAKE SEALS PER FIGURE AND DIMENSIONS IN CHART.
4. FASTENER HOLES ARE PICKED UP ON ASSEMBLY.
5. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE YELLOW INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70500-02060-193, -208 DRIP PAN SEAL.

FIGURE H-157. DRIP PAN SEAL



NOMENCLATURE	W WIDTH	L LENGTH	SIKORSKY PART NUMBER
COCKPIT DOOR JAMB SEALS	0.50	113.0	70000-00550-101
	0.62		70000-00550-103
		15.0	70000-00550-104

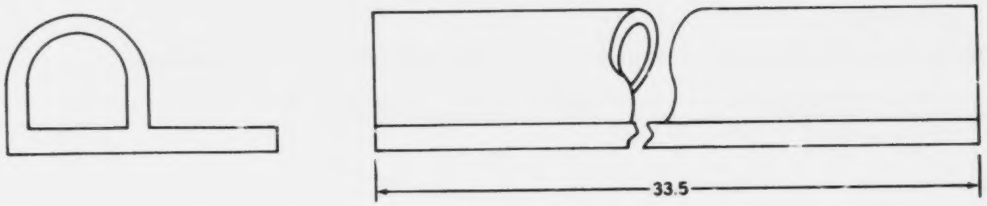
NOTES:

1. MAKE FROM 0.13-INCH-THICK RUBBER, SCE-7L, MIL-STD-670, NSN 9320-00-202-2225.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

PART NUMBER: 70000-00550-101, -103, -104 COCKPIT DOOR JAMB SEALS.

FIGURE H-158. COCKPIT DOOR JAMB SEALS



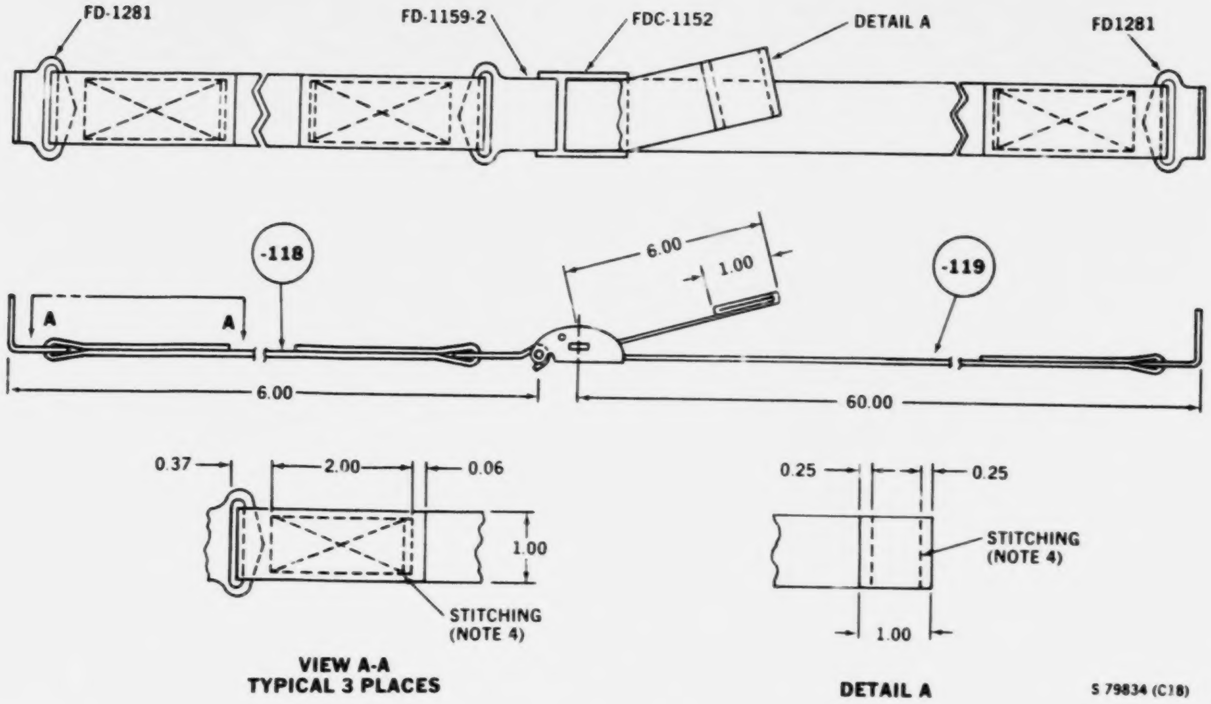
NOTES:
1. MAKE FROM NO. ZX-10047 RUBBER EXTRUSION, FSCM 76385.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: P/N 70216-02401-107 3Q 86
PART NUMBER 1986
THIRD QUARTER

4. TRIM TO FIT ON INSTALLATION.

PART NUMBER: 70000-00550-102 COCKPIT DOOR JAMB SEAL.

FIGURE H-159. COCKPIT DOOR JAMB SEALS


FD-1281
FD-1159-2
FDC-1152
DETAIL A
FD1281
-118
-119
A
A
6.00
1.00
6.00
60.00
0.37
2.00
0.06
1.00
STITCHING (NOTE 4)
0.25
0.25
STITCHING (NOTE 4)
1.00
S 79834 (C18)

VIEW A-A
TYPICAL 3 PLACES

DETAIL A

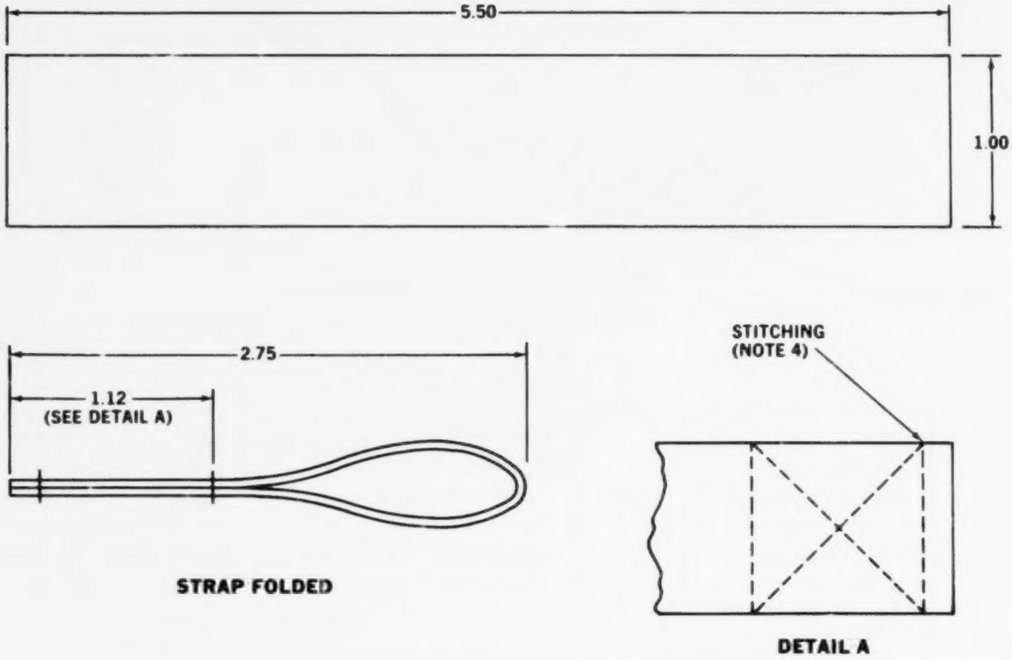
PART NUMBER	DESCRIPTION	QUANTITY	NSN
FD-1281	FITTING	2	6760-01-088-0003
70700-20313-118	STRAP	9.75 IN.	8315-00-263-3604
FD-1159-2	HOOK	1	5340-00-802-6886
FDC-1152	BUCKLE	1	5340-01-079-6667
70700-20313-119	STRAP	69.5 IN.	8315-00-263-3604
V-T-276, TYPE 1B3, TICKET NO. 16	THREAD, 4-PLY COTTON	AR	8310-00-530-1182

NOTES:

1. MAKE -118 STRAP PER FIGURE AND MATERIAL LISTED IN CHART. ASSEMBLE STRAP WITH LISTED FITTING AND HOOK TO MAKE -050 STRAP ASSEMBLY.
2. MAKE -119 STRAP PER FIGURE AND MATERIAL LISTED IN CHART. ASSEMBLE STRAP WITH LISTED FITTING AND BUCKLE TO MAKE -046 BUCKLE ASSEMBLY.
3. ALL DIMENSIONS ARE IN INCHES.
4. SEW STRAPS AS SHOWN IN VIEW A-A AND DETAIL A. STITCHING TO BE PER FED. STD 751 USING V-T-276 THREAD AS LISTED IN CHART.
5. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 70700-20313-118, -119 STRAP, STORAGE FRAME.

FIGURE H-160. STORAGE FRAME STRAP


5.50
1.00
2.75
1.12
(SEE DETAIL A)
STITCHING
(NOTE 4)
STRAP FOLDED
DETAIL A

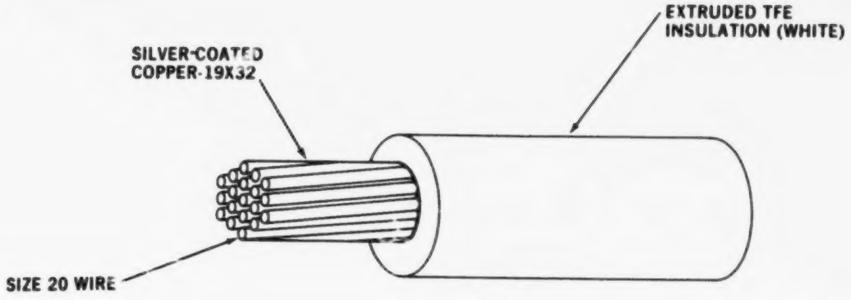
S 79837 (C18)

NOTES:

1. MAKE FROM 1.00 INCH WIDE x 5.50 INCH LONG, TYPE II, BLACK NYLON TAPE, MIL-W-4088, NSN 8305-00-811-1617.
2. ALL DIMENSIONS ARE IN INCHES.
3. FOLD AND SEW TAB TO CURTAIN, AS SHOWN, STITCHING TO BE PER FED. STD 751, USING VT-295, SIZE E, TYPE I, CLASS A, NYLON THREAD, NSN 8310-00-515-3367.
4. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 70700-20014-110 CABIN WINDOW CURTAIN PULL TAB.

FIGURE H-161. CURTAIN TAB


EXTRUDED TFE INSULATION (WHITE)
SILVER-COATED COPPER-19X32
SIZE 20 WIRE

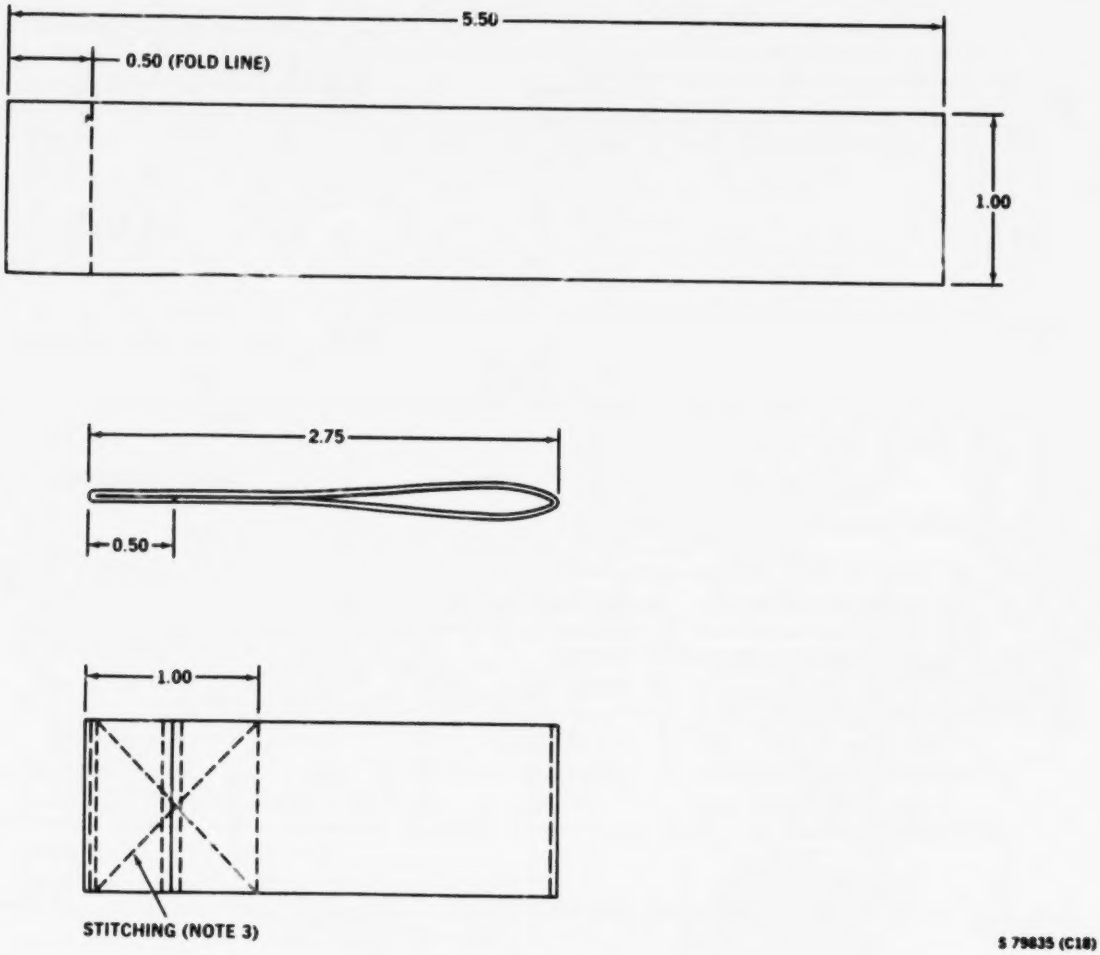
S 79836 (C18)

SIKORSKY PART NUMBER	SIZE	MAKE FROM	
		PART NUMBER	NSN
SS7313-20A1	20	M22759/11-20-9	6145-00-939-4964

NOTES:
1. MAKE FROM SILVER-COATED COPPER WIRE PER CHART.
2. CUT WIRE TO REQUIRED LENGTH.
3. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: SS7313-20A1 HIGH-TEMPERATURE ELECTRICAL WIRE.

FIGURE H-162. HIGH-TEMPERATURE ELECTRICAL WIRE

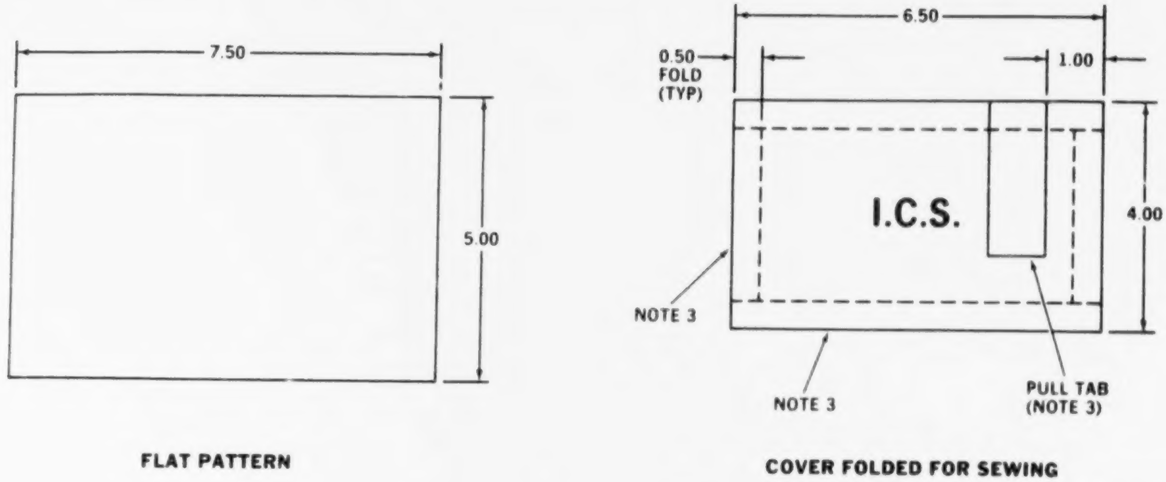

5.50
0.50 (FOLD LINE)
1.00
2.75
0.50
1.00
STITCHING (NOTE 3)
S 79835 (C18)

NOTES:

1. MAKE FROM 1.00-INCH-WIDE BLACK NYLON TAPE, TYPE II, MIL-W-4088, NSN 8305-00-811-1617.
2. ALL DIMENSIONS ARE IN INCHES.
3. FOLD AND SEW TAB AS SHOWN IN FIGURE. STITCHING TO BE PER FED. STD 751 USING V-T-295C THREAD, NSN 8310-00-515-3367.
4. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 70070-20013-106 CURTAIN TAB.

FIGURE H-163. CURTAIN TAB


7.50
5.00
FLAT PATTERN
6.50
0.50 FOLD (TYP)
1.00
I.C.S.
4.00
NOTE 3
NOTE 3
PULL TAB (NOTE 3)
COVER FOLDED FOR SEWING

S 79838 (C18)

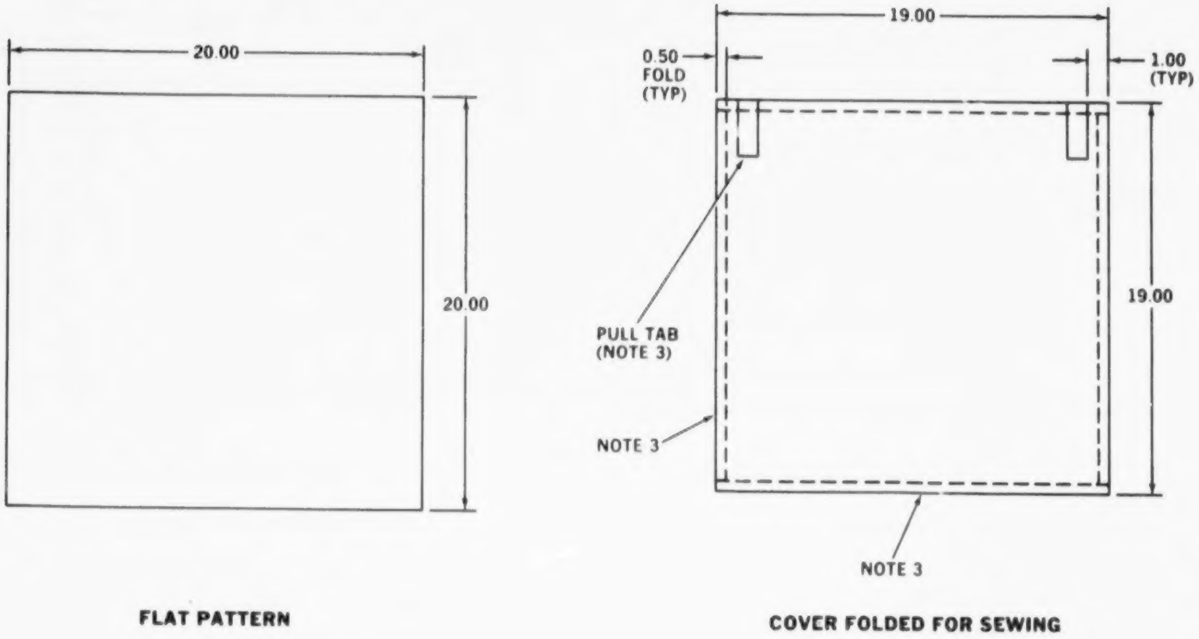
PART NUMBER	DESCRIPTION	QUANTITY	MAKE FROM
70070-20013-152	COVER	1	NOTE 1
70070-20013-106	PULL TAB	1	FIGURE F-166
70070-20013-116	TAPE HOOK	2	FIGURE F-32
70070-20013-118	TAPE HOOK	2	FIGURE F-32
V-T-295, SIZE E, TYPE I, BLACK	THREAD	AR	NSN 8310-00-515-3367

NOTES:

1. MAKE FROM DARK GREEN NYLON CLOTH, TYPE I, CLASS III, MIL-C-20696, NSN 8305-00-965-1654, AND ATTACHING PARTS LISTED IN CHART.
2. CUT CLOTH TO FLAT PATTERN DIMENSIONS.
3. FOLD CLOTH 1/2 INCH UNDER ON ALL SIDES. POSITION 70070-20013-116, 70070-20013-118 TAPE HOOKS, 70070-20013-106 PULL TAB ON FOLDED COVER AND SEW WITH DOUBLE ROW STITCH.
4. STITCHING TO BE PER FED. STD 751 USING V-T-295 BLACK NYLON THREAD.
5. ON AFT SIDE OF PART, BLACK INK STENCIL IN 1/2-INCH LETTERS - I.C.S.
6. IDENTIFY PARTS PER MIL-STD-130. APPLY IDENTIFICATION ON FORWARD SIDE.

PART NUMBER: 70070-20013-152 BLACKOUT CURTAIN COVER.

FIGURE H-164. BLACKOUT CURTAIN COVER


20.00
20.00
FLAT PATTERN
19.00
0.50
FOLD
(TYP)
1.00
(TYP)
19.00
PULL TAB
(NOTE 3)
NOTE 3
NOTE 3
COVER FOLDED FOR SEWING
S 79839 (C18)

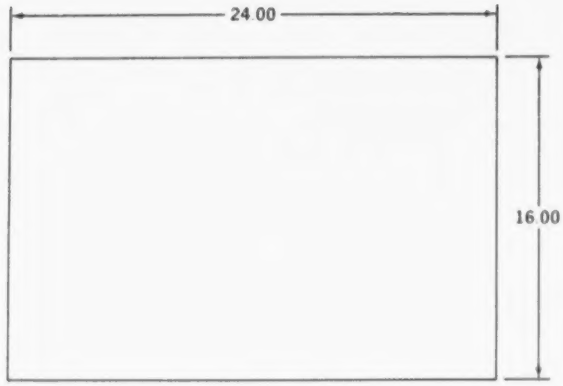
PART NUMBER	DESCRIPTION	QUANTITY	MAKE FROM
70070-20013-153	COVER	1	NOTE 1
70070-20013-106	PULL TAB	2	FIGURE F-166
70070-20013-112	TAPE HOOK	2	FIGURE F-32
70070-20013-114	TAPE HOOK	2	FIGURE F-32
V-T-295, SIZE E, TYPE 1, BLACK	THREAD	AR	NSN 8310-00-515-3367

NOTES:

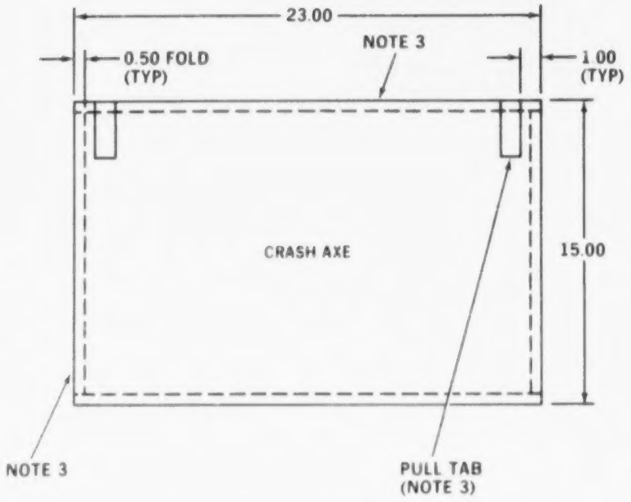
1. MAKE FROM DARK GREEN NYLON CLOTH, TYPE 1, CLASS III, MIL-C-20696, NSN 8305-00-965-1654, AND ATTACHING PARTS LISTED IN CHART.
2. CUT CLOTH TO FLAT PATTERN DIMENSIONS.
3. FOLD CLOTH 1/2 INCH UNDER ON ALL SIDES. POSITION 70070-20013-112, 70070-20013-114 TAPE HOOKS, 70070-20013-106 PULL TABS ON FOLDED COVER AND SEW WITH DOUBLE ROW STITCH.
4. STITCHING TO BE PER FED. STD 751, USING V-T-295 BLACK NYLON THREAD.
5. IDENTIFY PARTS PER MIL-STD-130, APPLY IDENTIFICATION TO FORWARD SIDE.

PART NUMBER: 70070-20013-153 BLACKOUT CURTAIN COVER.

FIGURE H-165. BLACKOUT CURTAIN COVER



FLAT PATTERN



COVER FOLDED FOR SEWING

S 79840 (C18)

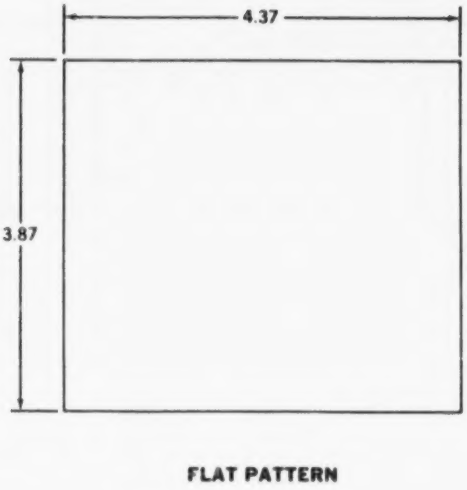
PART NUMBER	DESCRIPTION	QUANTITY	MAKE FROM
70070-20013-154	COVER	1	NOTE 1
70070-20013-106	PULL TAB	2	FIGURE F-166
70070-20013-108	TAPE HOOK	2	FIGURE F-32
70070-20013-110	TAPE HOOK	1	FIGURE F-32
V-T-295, SIZE E, BLACK	THREAD	AR	NSN 8310-00-515-3367

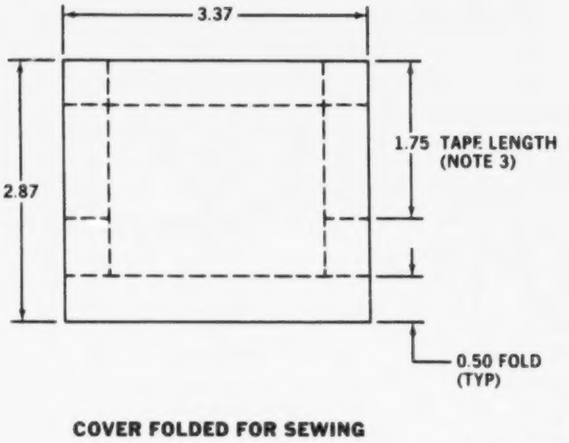
NOTES:

1. MAKE FROM DARK GREEN NYLON CLOTH, TYPE 1, CLASS III, MIL-C-20696, NSN 8305-00-965-1654, AND ATTACHING PARTS LISTED IN CHART.
2. CUT CLOTH TO FLAT PATTERN DIMENSIONS.
3. FOLD CLOTH 1/2 INCH UNDER ON ALL SIDES. POSITION 70070-20013-108, 70070-20013-110 TAPE HOOKS, 70070-20013-106 PULL TABS ON FOLDED COVER AND SEW WITH DOUBLE ROW STITCH.
4. STITCHING TO BE PER FED. STD 751, USING V-T-295 BLACK NYLON THREAD.
5. ON AFT SIDE OF PART BLACK INK STENCIL IN 1/2-INCH LETTERS - CRASH AXE.
6. IDENTIFY PARTS PER MIL-STD-130. APPLY IDENTIFICATION TO FORWARD SIDE.

PART NUMBER: 70070-20013-154 BLACKOUT CURTAIN COVER.

FIGURE H-166. BLACKOUT CURTAIN COVER


4.37
3.87
FLAT PATTERN


3.37
2.87
1.75 TAPE LENGTH (NOTE 3)
0.50 FOLD (TYP)
COVER FOLDED FOR SEWING

S 79841 (C18)

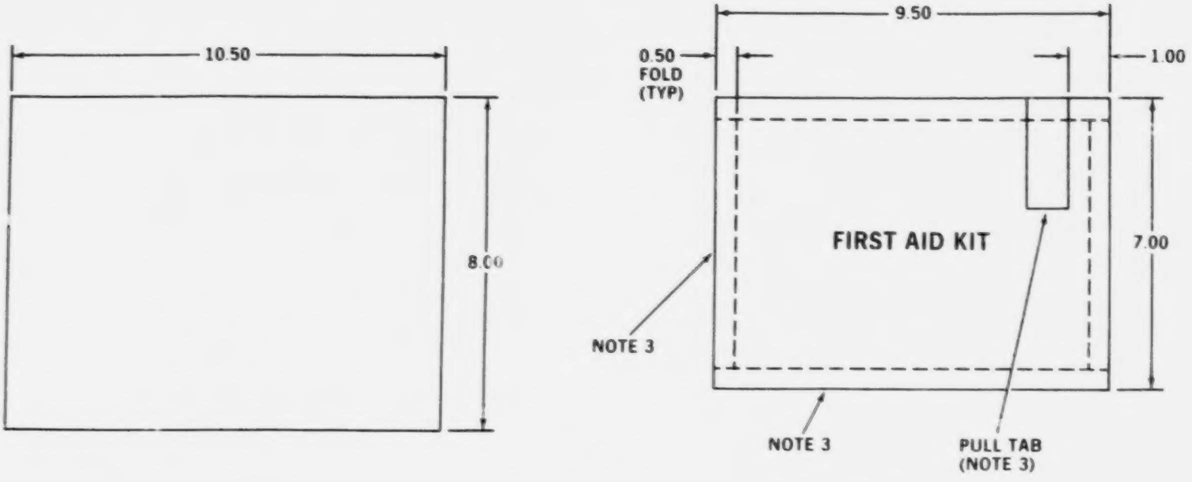
PART NUMBER	DESCRIPTION	QUANTITY	MAKE FROM
70070-20013-155	COVER	1	NOTE 1
70070-20013-134	TAPE HOOK	2	FIGURE F-32
V-T-295, SIZE E, BLACK	THREAD	AR	NSN 8310-00-515-3367

NOTES:

1. MAKE FROM DARK GREEN NYLON CLOTH, TYPE 1, CLASS III, MIL-C-20696, NSN 8305-00-965-1654, AND ATTACHING PARTS LISTED IN CHART.
2. CUT CLOTH TO FLAT PATTERN DIMENSIONS.
3. FOLD CLOTH 1/2 INCH UNDER ON ALL SIDES. POSITION 70070-20013-134 TAPE HOOKS ON FOLDED COVER AND SEW WITH DOUBLE ROW STITCH.
4. STITCHING TO BE PER FED. STD 751, USING V-T-295 BLACK NYLON THREAD.
5. IDENTIFY PARTS PER MIL-STD-130. APPLY IDENTIFICATION ON FORWARD SIDE.

PART NUMBER: 70070-20013-155 BLACKOUT CURTAIN COVER.

FIGURE H-167. BLACKOUT CURTAIN COVER



FLAT PATTERN

COVER FOLDED FOR SEWING

S 79842 (C18)

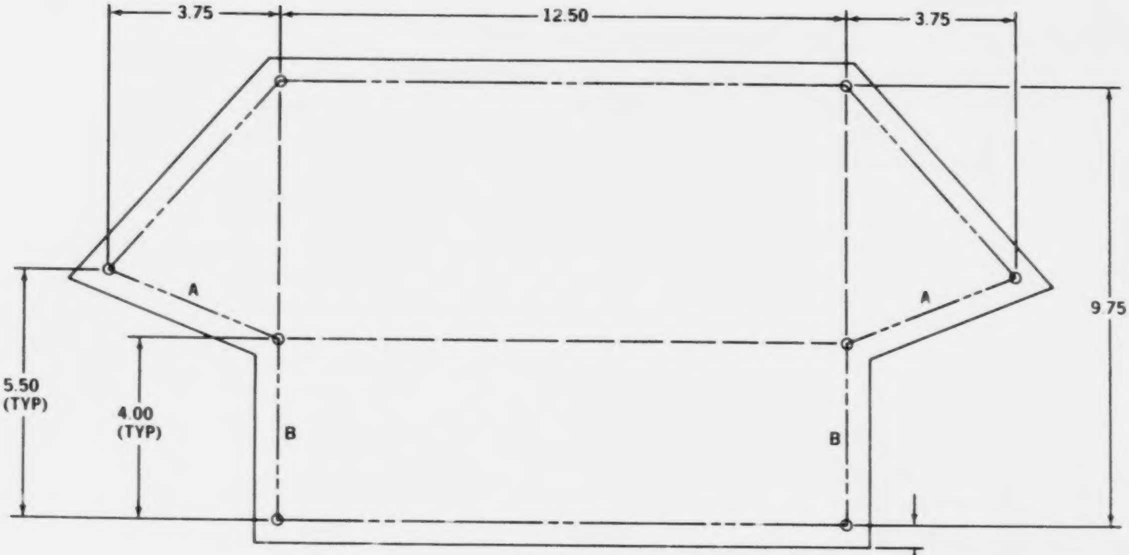
PART NUMBER	DESCRIPTION	QUANTITY	MAKE FROM
70070-20013-156	COVER	1	NOTE 1
70070-20013-106	PULL TAB	1	FIGURE F-166
70070-20013-120	TAPE HOOK	2	FIGURE F-32
70070-20013-122	TAPE HOOK	2	FIGURE F-32
V-T-295, SIZE E, BLACK	THREAD	AR	NSN 8310-00-515-3367

NOTES:

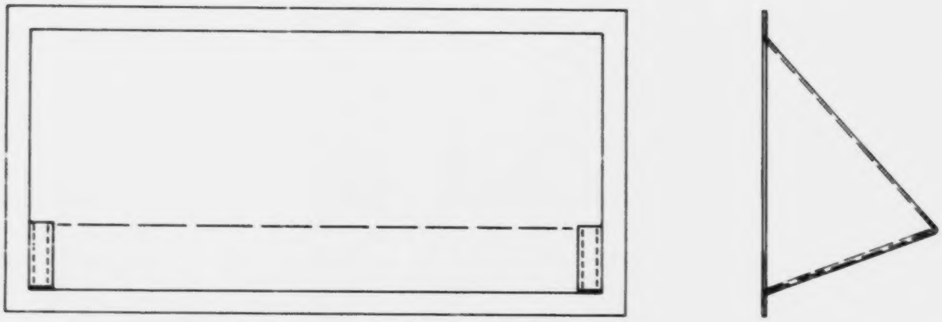
1. MAKE FROM DARK GREEN NYLON CLOTH, TYPE 1, CLASS III, MIL-C-20696, NSN 8305-00-965-1654, AND ATTACHING PARTS LISTED IN CHART.
2. CUT CLOTH TO FLAT PATTERN DIMENSIONS.
3. FOLD CLOTH 1/2 INCH UNDER ON ALL SIDES. POSITION 70070-20013-120, 70070-20013-122 TAPE HOOKS, 70070-20013-106 PULL TAB ON FOLDED COVER AND SEW WITH DOUBLE ROW STITCH.
4. STITCHING TO BE PER FED. STD 751, USING BLACK NYLON THREAD.
5. ON AFT FACING SIDE OF PART, BLACK INK STENCIL IN 1/2-INCH LETTERS - FIRST AID KIT.
6. IDENTIFY PARTS PER MIL-STD-130. APPLY IDENTIFICATION ON FORWARD SIDE.

PART NUMBER: 70070-20013-156 BLACKOUT CURTAIN COVER.

FIGURE H-168. BLACKOUT CURTAIN COVER



FLAT PATTERN



VIEW LOOKING INTO POCKET AFTER SEWING

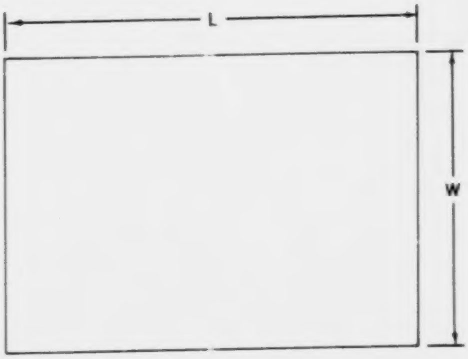
S 79843 (C18)

NOTES:

1. MAKE FROM DARK GREEN NYLON CLOTH, TYPE 1, CLASS III, MIL-C-20696, NSN 8305-00-965-1654.
2. CUT CLOTH TO FLAT PATTERN DIMENSIONS.
3. ALL FOLDS BEFORE SEWING TO BE AT LEAST 0.50 INCH.
4. STITCHING TO BE PER FED. STD 751, USING NYLON THREAD, V-T-295, SIZE E, COLOR BLACK, NSN 8310-00-515-3367.
5. SEW FOLDS A AND B (EACH SIDE) WITH DOUBLE ROW STITCHING ON WRONG SIDE AND REVERSE POCKET FOR END PRODUCT.
6. IDENTIFY PARTS PER MIL-STD-130. APPLY IDENTIFICATION ON FORWARD SIDE.

PART NUMBER: 70070-20013-158 BLACKOUT CURTAIN POCKET.

FIGURE H-169. BLACKOUT CURTAIN COVER



S 79714 (C18)

PANEL	SIZE	
SIKORSKY PART NUMBER	LENGTH (L)	WIDTH (W)
70500-02066-124	5.30	2.00
70500-02066-137	37.20	9.80
70500-02066-138	37.20	9.80
70500-02066-141	5.40	4.00
70500-02066-143	5.20	1.92
70500-02066-145	5.20	3.00
70500-02066-147	5.52	4.72
70500-02066-148	4.72	3.92
70500-02066-149	4.72	1.28
70500-02066-155	3.80	3.36
70500-02066-156	10.72	3.36
70500-02066-165	5.00	2.48
70500-02066-166	5.00	2.88
70500-02066-167	6.00	4.20
70500-02066-168	5.28	4.20
70500-02066-169	5.28	5.04
70500-02066-170	5.28	2.96
70500-02066-177	16.20	3.20
70500-02066-178	16.20	3.76
70500-02066-179	16.20	3.12
70500-02066-180	16.20	3.92
70500-02066-181	12.60	4.00
70500-02066-182	7.40	1.92
70500-02066-214	6.75	6.30
70500-02066-218	15.52	2.82
70500-02066-265	15.52	2.82
70500-02066-219	7.40	2.82
70500-02066-266	7.40	2.82
70500-02066-220	6.00	2.84

FIGURE H-170. FOIL PANEL (SOUND-ABSORBING) - SQUARE OR RECTANGULAR CONFIGURATION (SHEET 1 OF 2)

PANEL	SIZE	
SIKORSKY PART NUMBER	LENGTH (L)	WIDTH (W)
70500-02066-267	6.00	2.84
70500-02066-221	6.95	2.84
70500-02066-223	5.94	2.84
70500-02066-225	15.14	5.94
70500-02066-226	15.14	5.99
70500-02066-227	13.80	5.18
70500-02066-228	14.42	5.09
70500-02066-229	13.85	5.15
70500-02066-230	14.77	5.00
70500-02066-233	6.72	5.12
70500-02066-234	6.72	4.20
70500-02066-235	4.28	4.20
70500-02066-238	16.12	5.12
70500-02066-239	16.12	3.52
70500-02066-243	6.35	1.08
70500-02066-244	6.30	2.48
70500-02066-245	6.34	6.30
70500-02066-248	8.50	6.65
70500-02066-258	5.15	1.72
70500-02066-263	3.14	2.38
70500-02066-272	8.32	5.12
70500-02066-274	5.60	4.16
70500-02066-275	4.16	1.12
70500-02066-276	4.80	3.68
70500-02066-277	3.68	3.52
70500-02066-296	3.52	3.20
70500-02066-297	4.80	4.32
70500-02066-298	4.32	2.80

NOTES:

1. MAKE FROM DAMPING FOIL, SJ2017X, FSCM 76381.
2. ALL DIMENSIONS ARE IN INCHES.
3. CUT DAMPING FOIL TO RECTANGULAR DIMENSIONS.
4. MEASURE AND MARK FINAL DIMENSIONS ON FOIL.
5. TRIM TO REQUIRED SIZE. ROUND OFF CORNERS TO PREVENT DELAMINATION. MINIMUM RADIUS IS 0.28-INCH.
6. IDENTIFY PART PER MIL-STD-130.

FIGURE H-170. FOIL PANEL (SOUND-ABSORBING) - SQUARE OR RECTANGULAR CONFIGURATION (SHEET 2 OF 2)

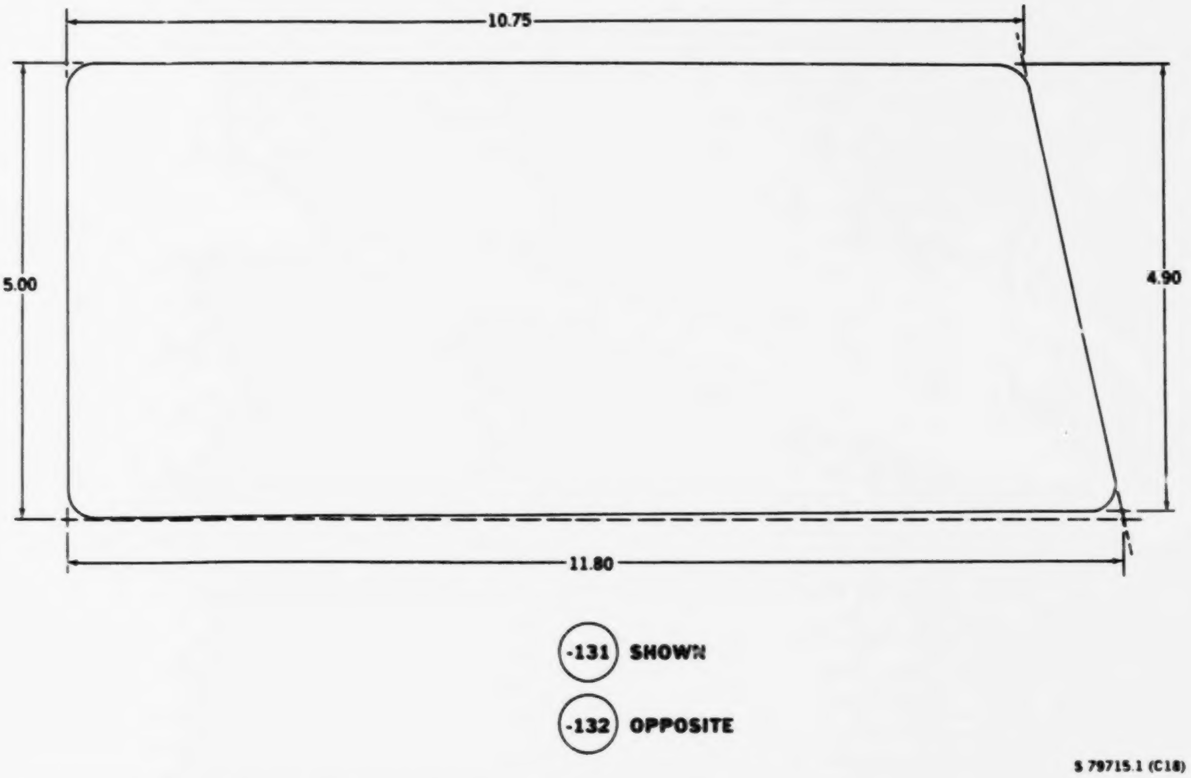

10.75
5.00
4.90
11.80
(-131) SHOWN
(-132) OPPOSITE
S 79715.1 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 1 OF 57)

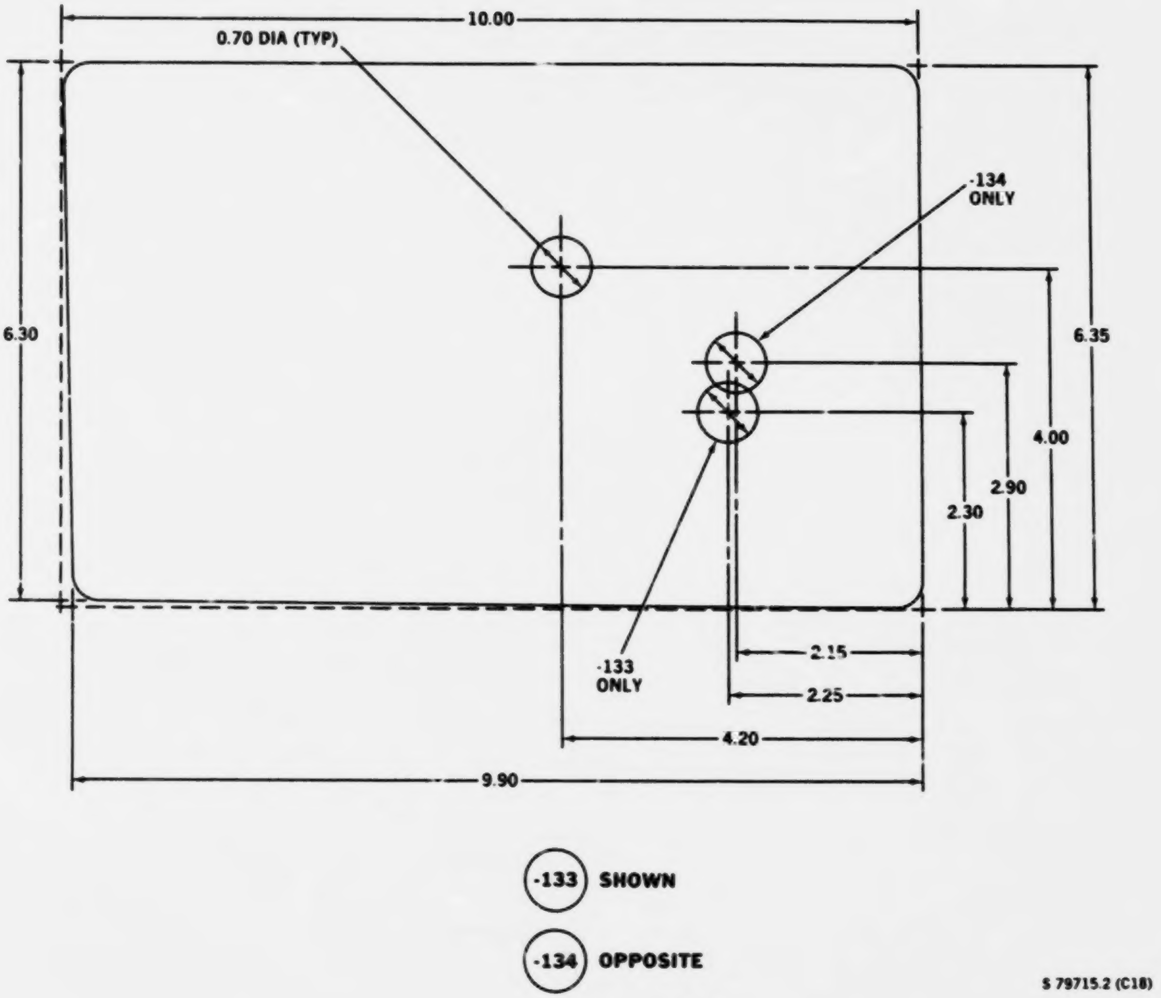

10.00
0.70 DIA (TYP)
-134
ONLY
6.30
6.35
4.00
2.90
2.30
-133
ONLY
2.15
2.25
4.20
9.90
-133 SHOWN
-134 OPPOSITE
S 79715.2 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 2 OF 57)

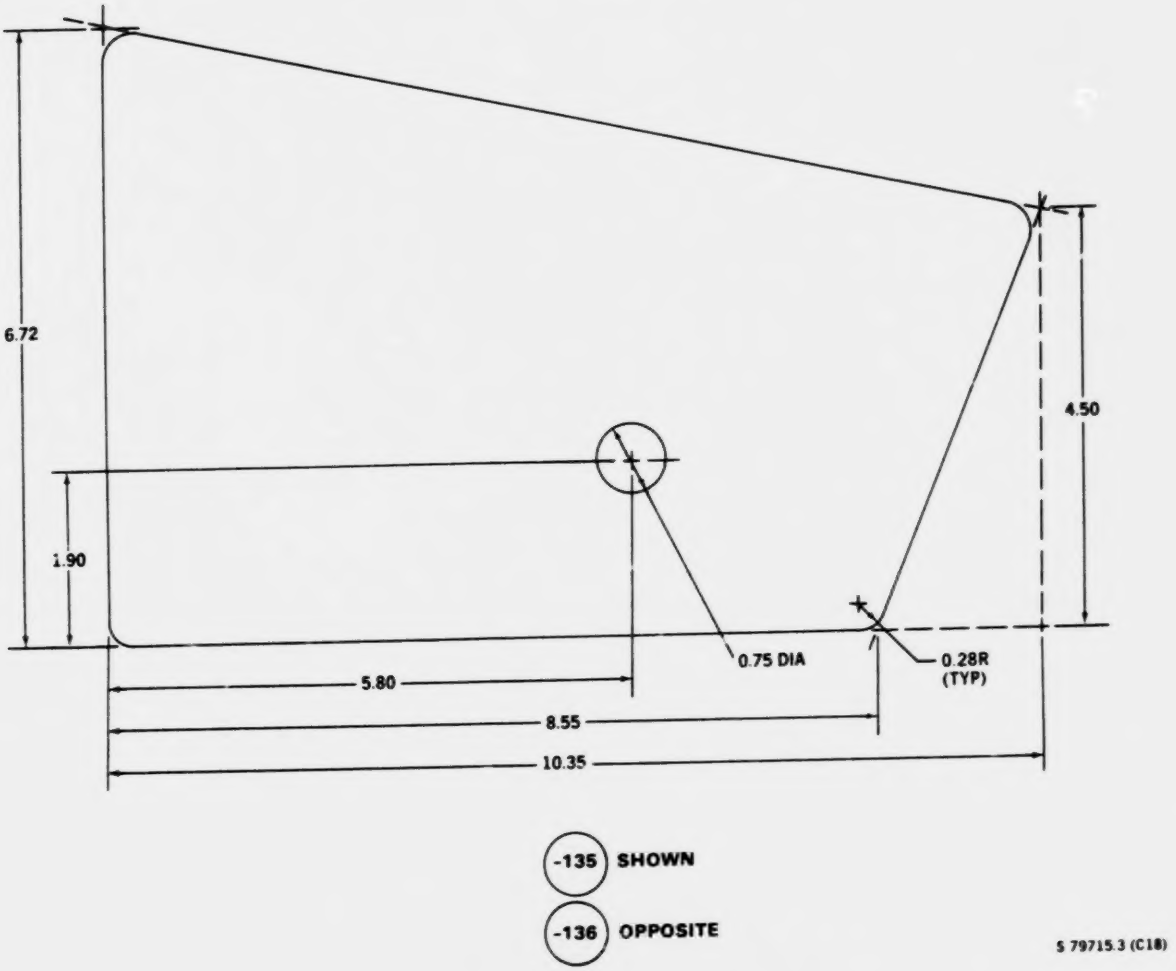
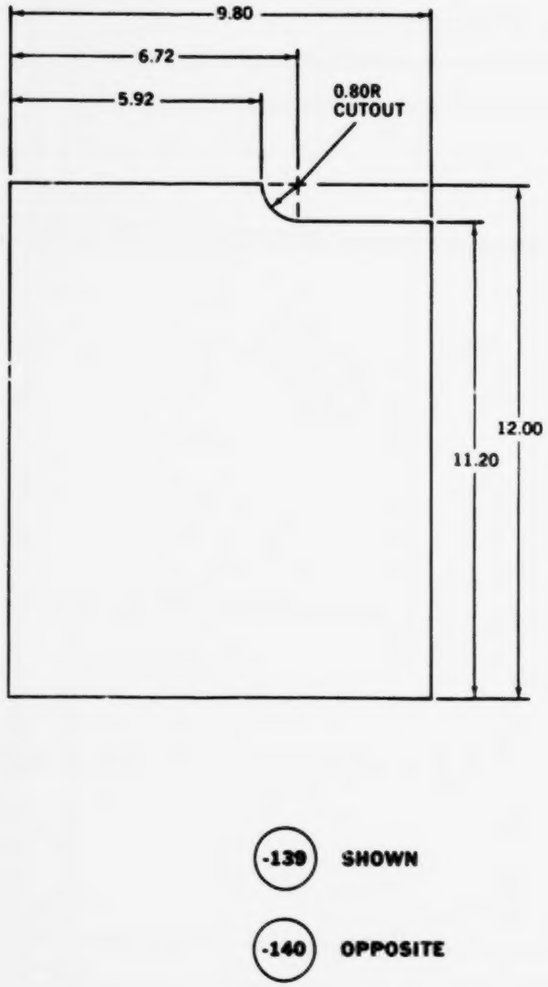
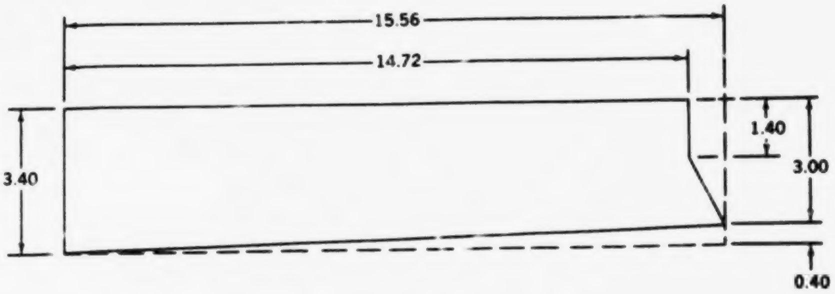

6.72
4.50
1.90
0.75 DIA
0.28R
(TYP)
5.80
8.55
10.35
-135 SHOWN
-136 OPPOSITE
S 79715.3 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 3 OF 57)

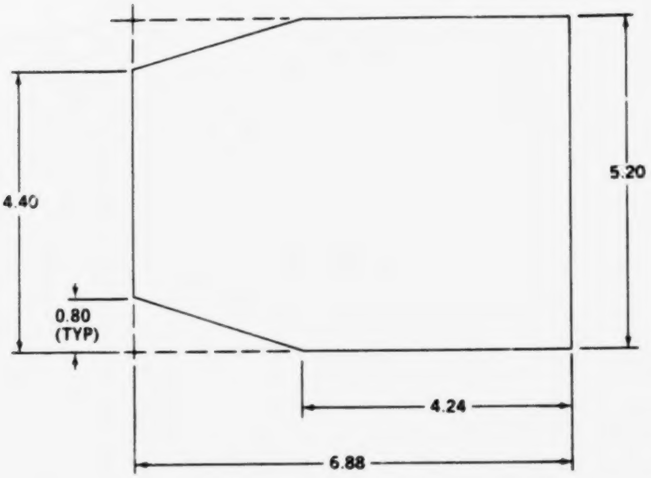

9.80
6.72
5.92
0.80R
CUTOUT
12.00
11.20
-139 SHOWN
-140 OPPOSITE

S 79715.4 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 4 OF 57)


15.56
14.72
3.40
1.40
3.00
0.40

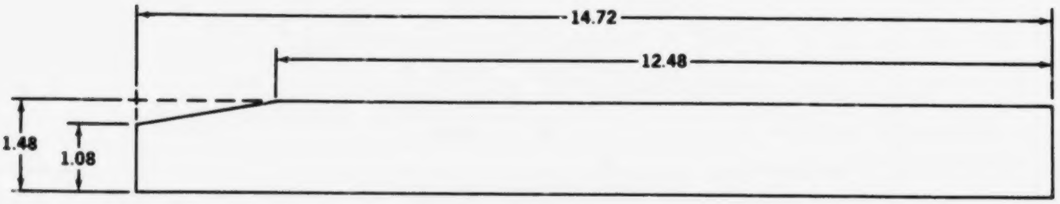
-142


4.40
5.20
0.80
(TYP)
4.24
6.88

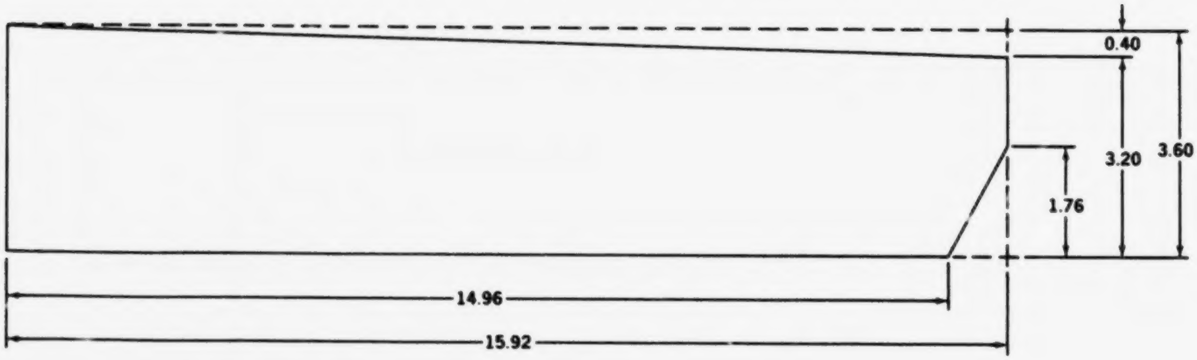
-144

S 79715.5 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 5 OF 57)


14.72
12.48
1.48
1.08

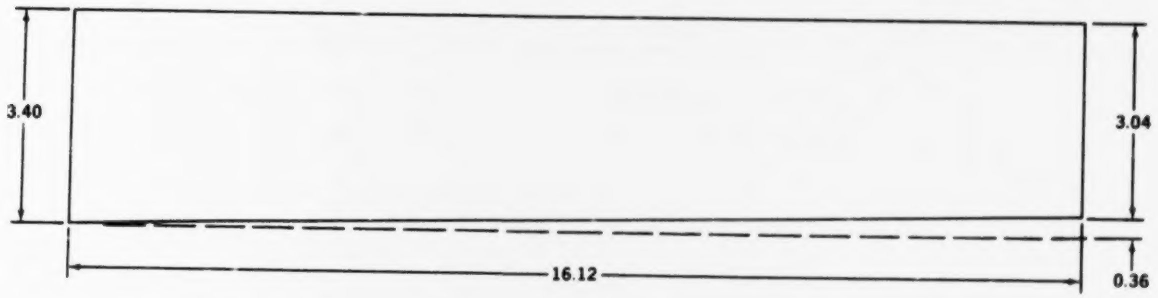
-146


0.40
3.20
3.60
1.76
14.96
15.92

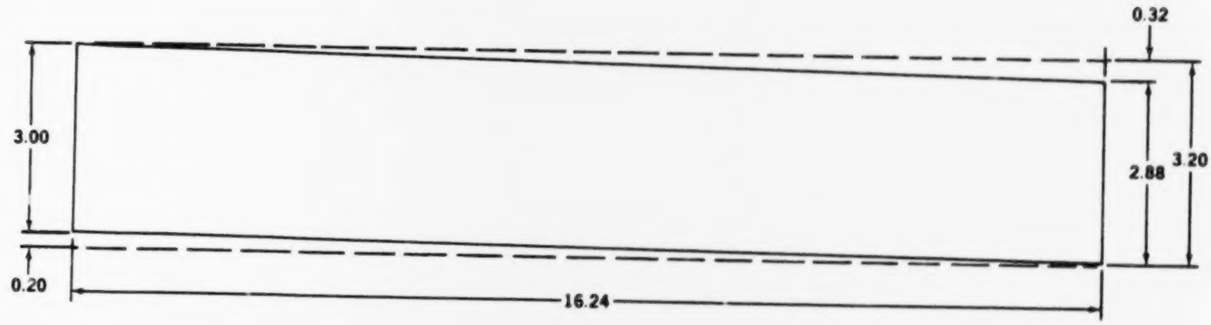
-150

S 79715.6 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 6 OF 57)


3.40
3.04
16.12
0.36

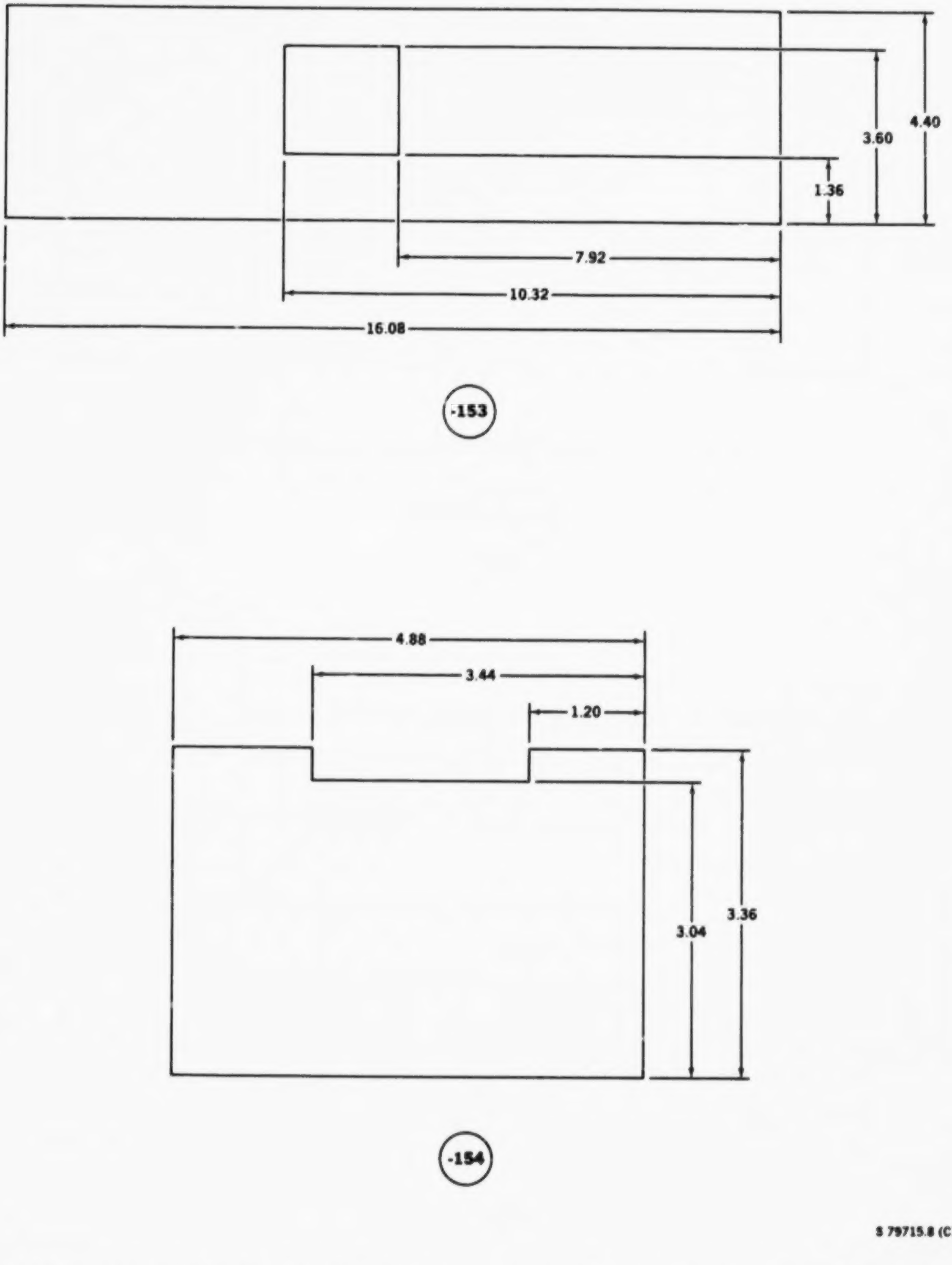
-151


0.32
3.00
2.88
3.20
0.20
16.24

-152

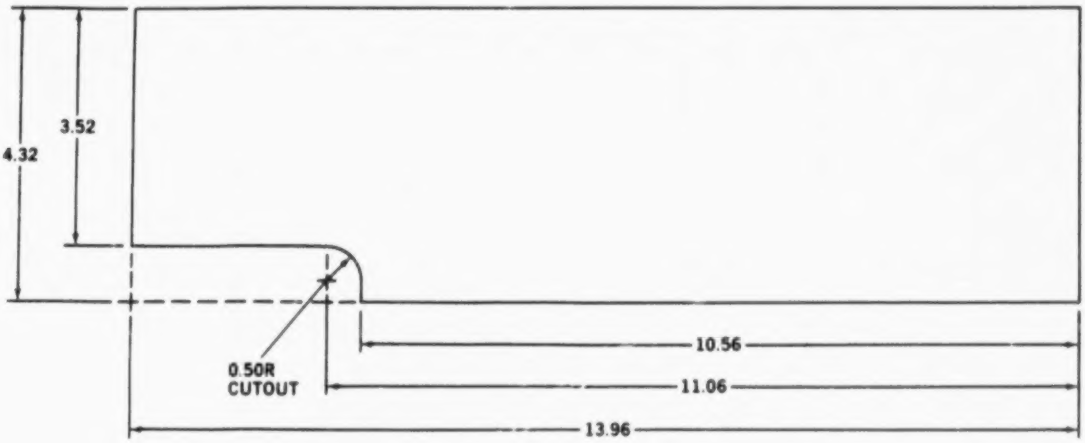
S 79715.7 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 7 OF 57)


4.40
3.60
1.36
7.92
10.32
16.08
-153
4.88
3.44
1.20
3.36
3.04
-154

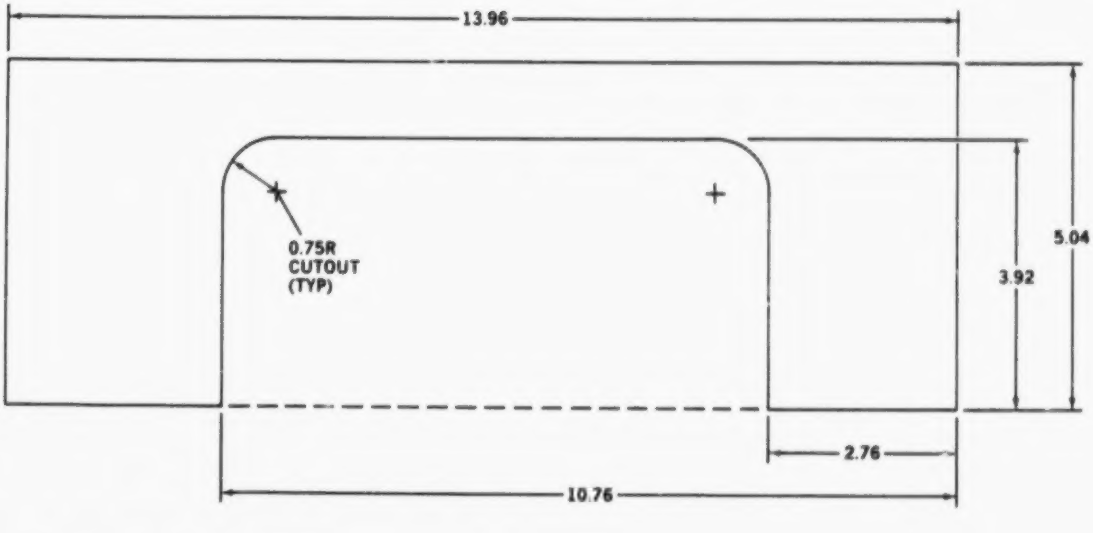
S 79715.8 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 8 OF 57)


4.32
3.52
0.50R
CUTOUT
10.56
11.06
13.96

(-157) **SHOWN**

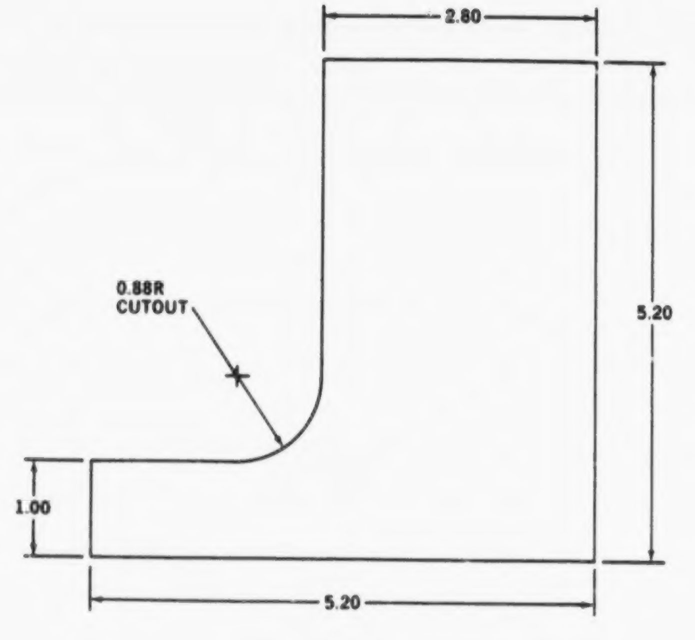
(-158) **OPPOSITE**


13.96
0.75R
CUTOUT
(TYP)
5.04
3.92
2.76
10.76

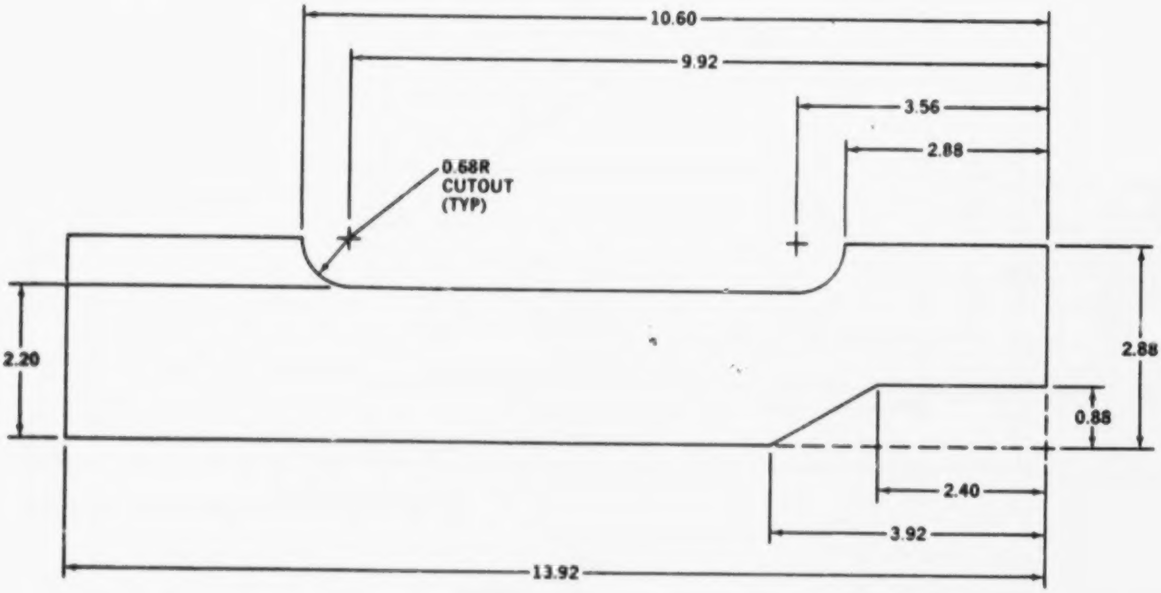
(-159)

S 79715.9 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 9 OF 57)


2.80
5.20
0.88R
CUTOUT
1.00
5.20

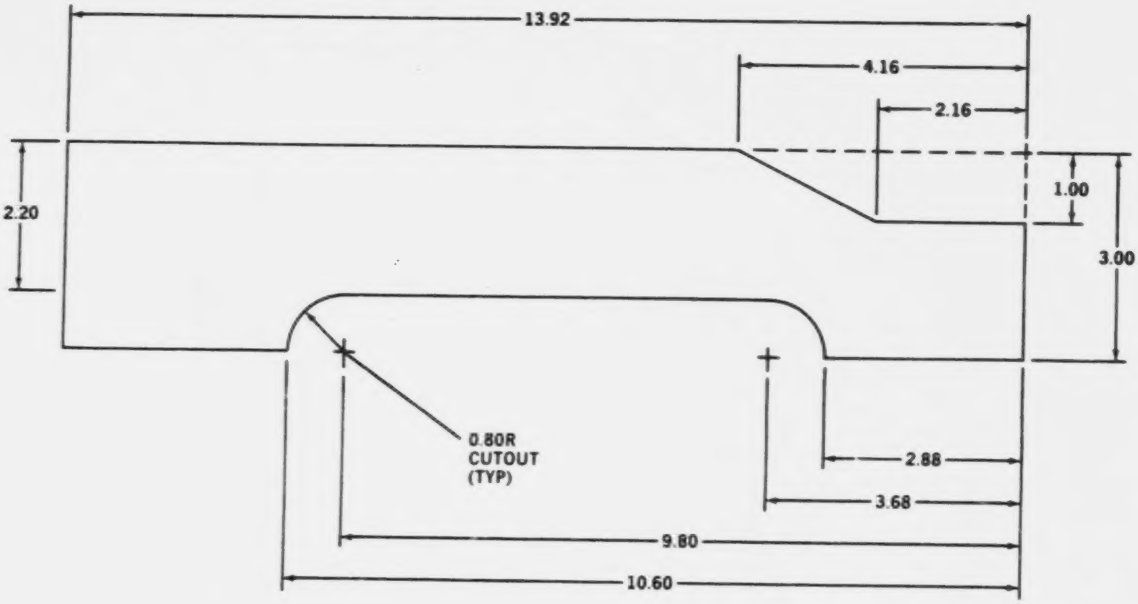
-160


10.60
9.92
3.56
2.88
0.68R
CUTOUT
(TYP)
2.20
2.88
0.88
2.40
3.92
13.92

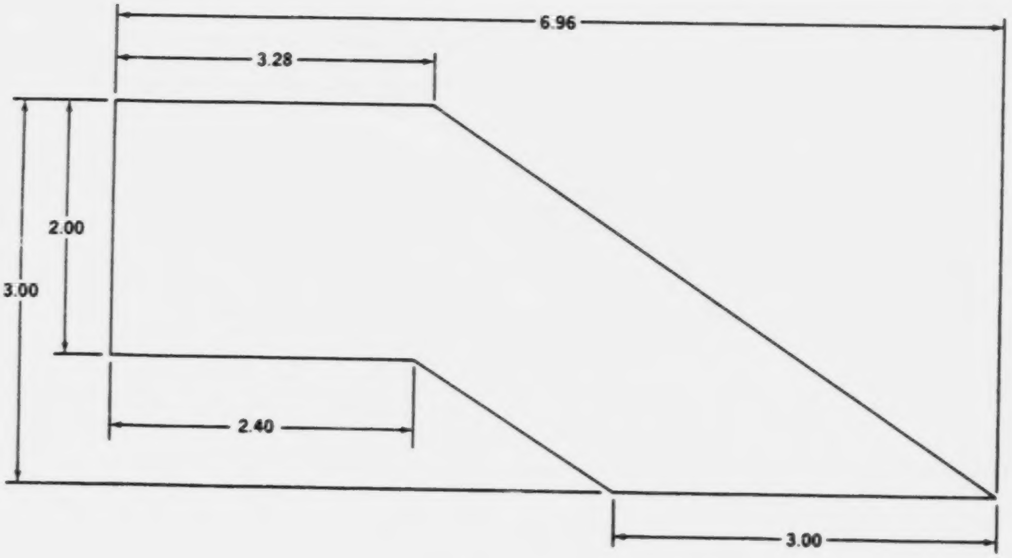
-161

S 79715.10 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 10 OF 57)


13.92
4.16
2.16
2.20
1.00
3.00
0.80R
CUTOUT
(TYP)
2.88
3.68
9.80
10.60

(-162)

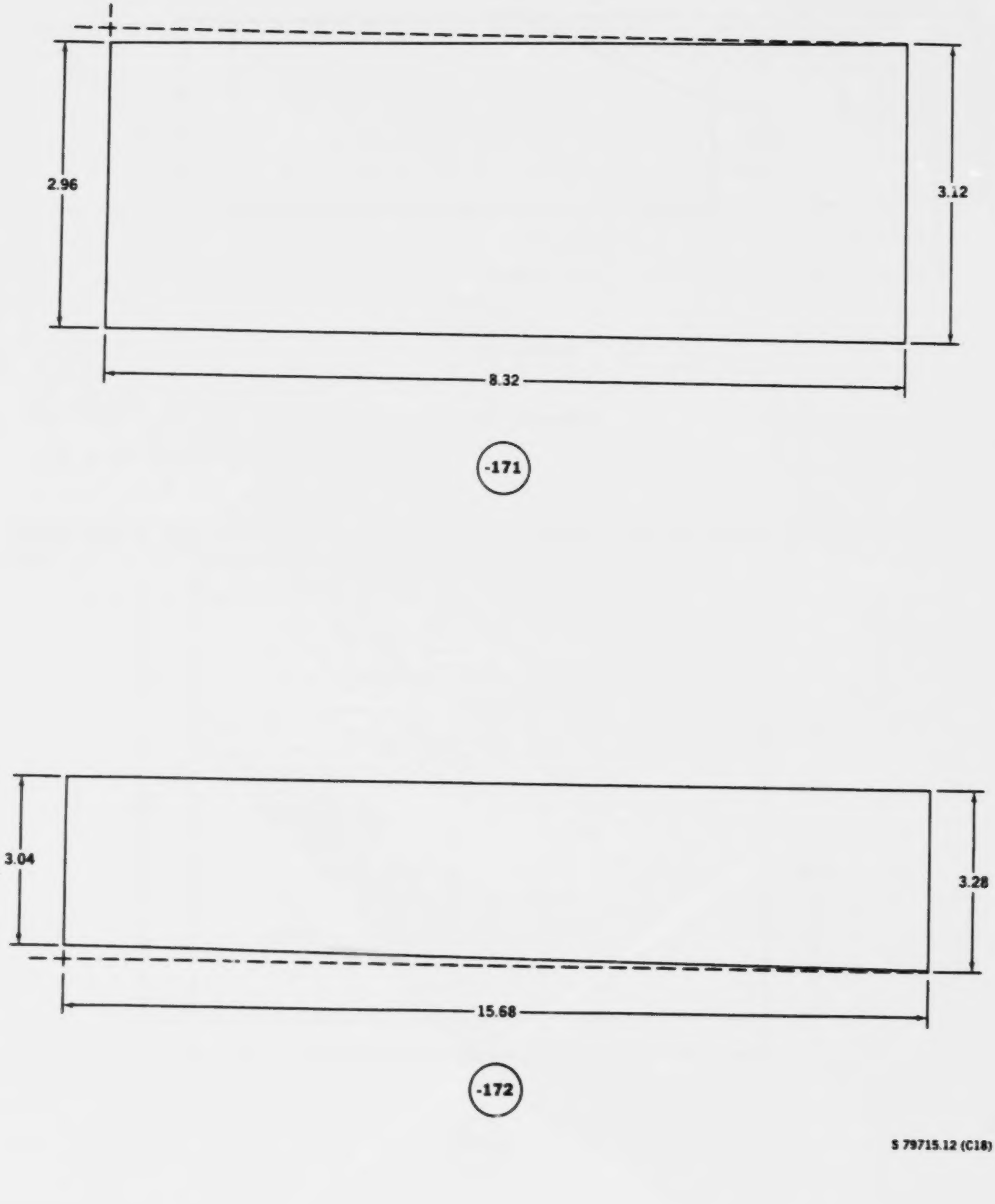

6.96
3.28
2.00
3.00
2.40
3.00

(-163) SHOWN

(-164) OPPOSITE

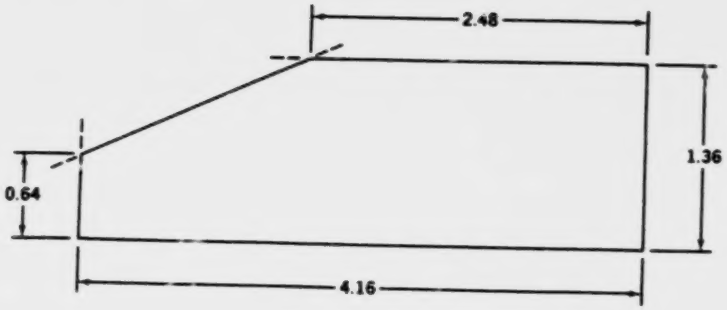
S 79715.11 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 11 OF 57)

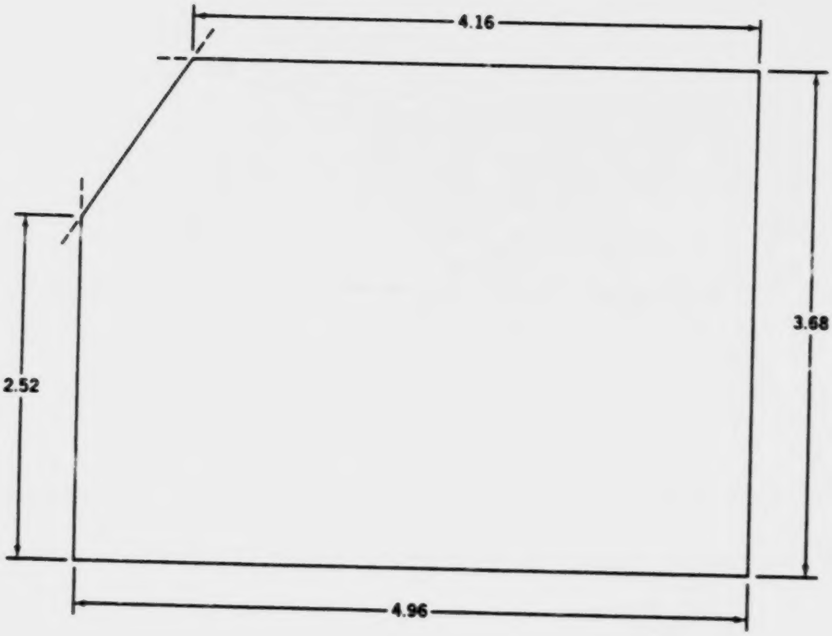

2.96
3.12
8.32
-171
3.04
3.28
15.68
-172

S 79715.12 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 12 OF 57)


2.48
1.36
0.64
4.16

-173


4.16
3.68
2.52
4.96

-174

S 79715.13 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 13 OF 57)

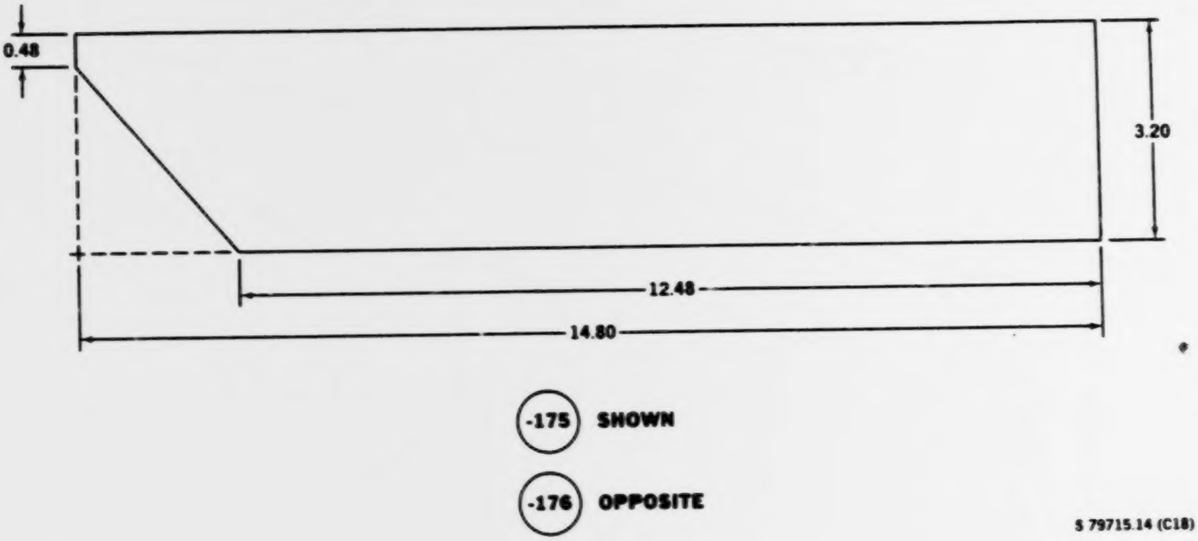
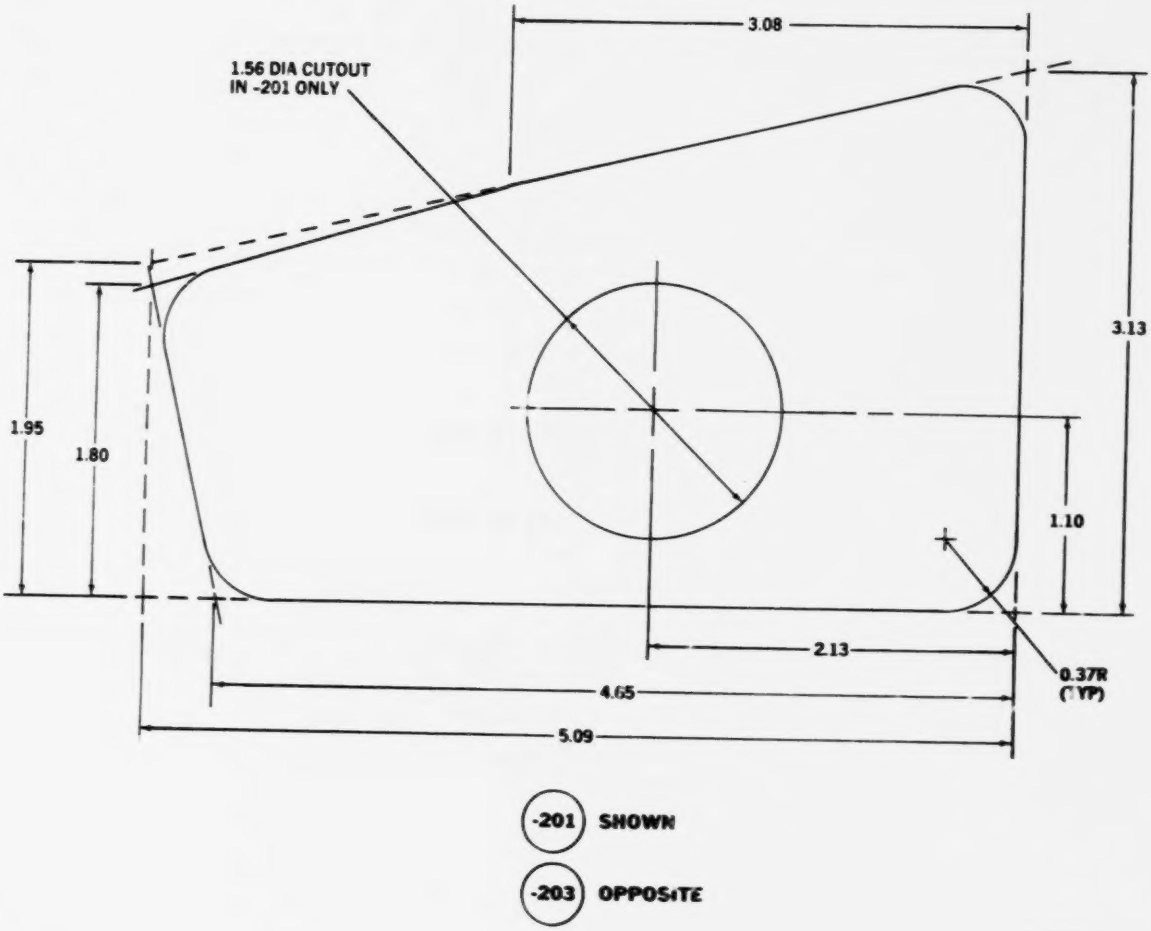
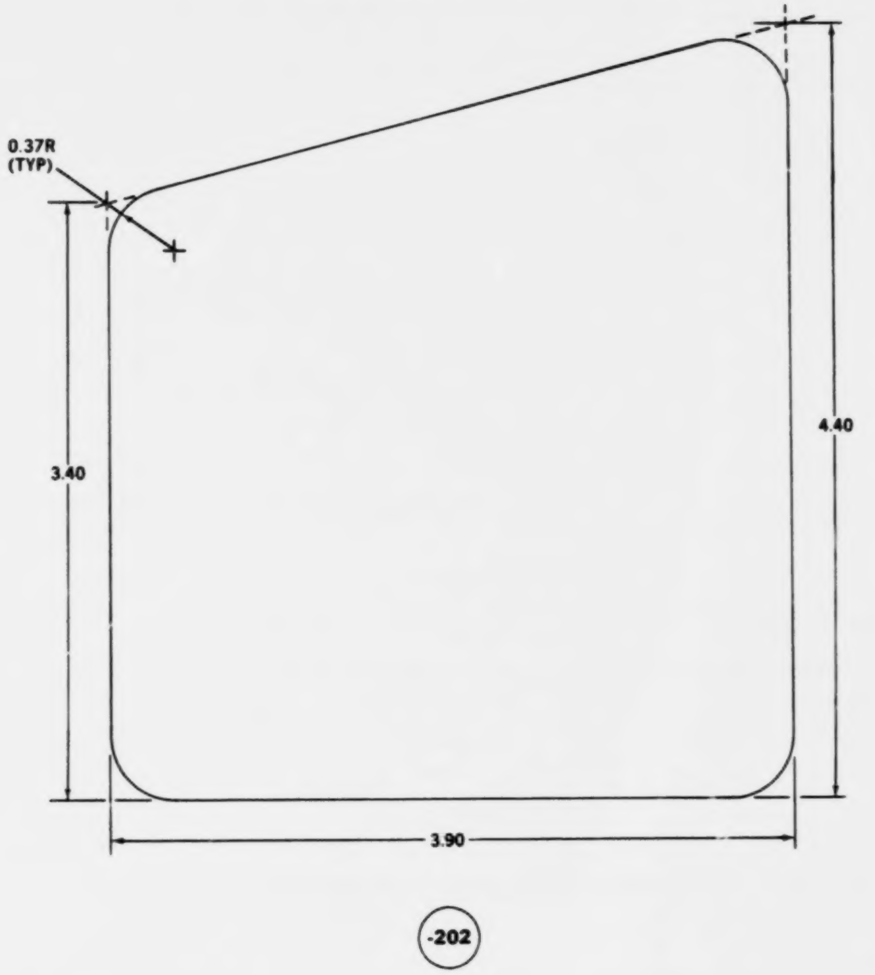

0.48
3.20
12.48
14.80
-175 SHOWN
-176 OPPOSITE
S 79715.14 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 14 OF 57)


3.08
1.56 DIA CUTOUT
IN -201 ONLY
3.13
1.95
1.80
1.10
2.13
4.65
5.09
0.37R
(TYP)
-201 SHOWN
-203 OPPOSITE

S 79715.15 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 15 OF 57)


0.37R
(TYP)
3.40
4.40
3.90
-202

S 79715.16 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 16 OF 57)

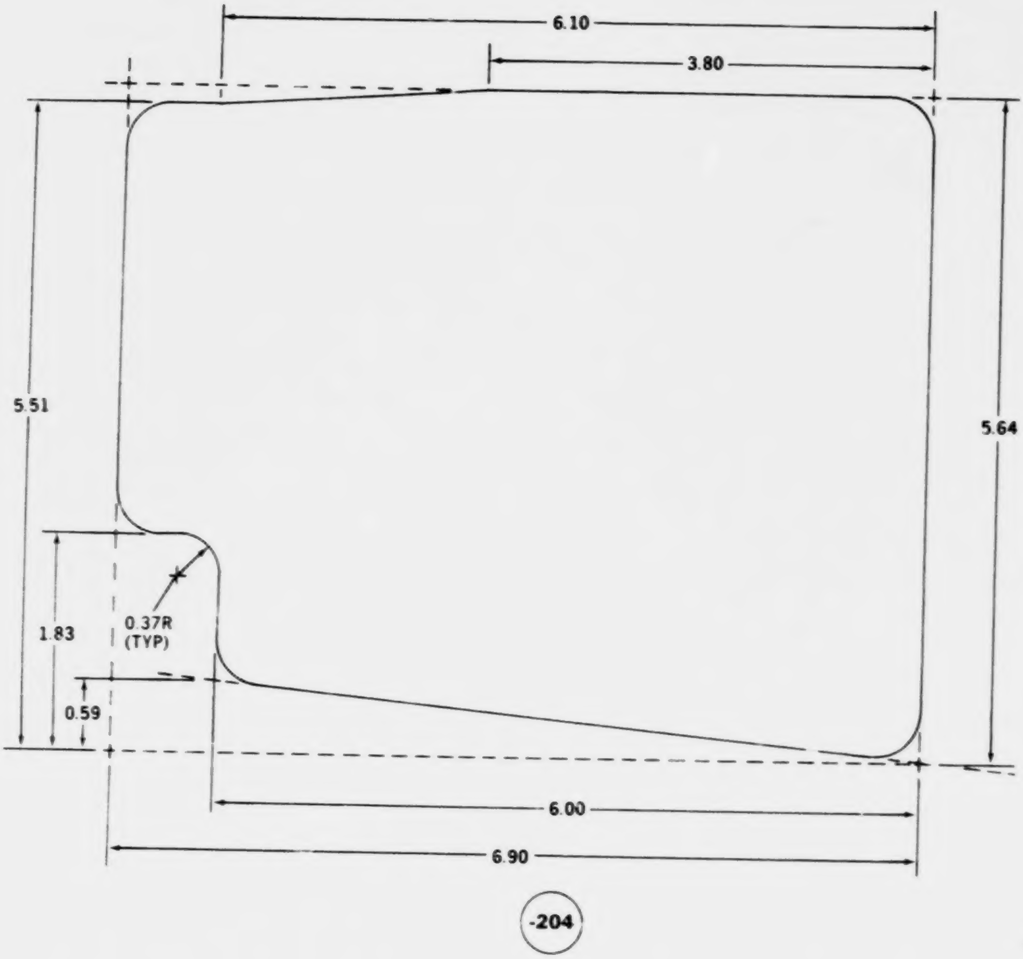

6.10
3.80
5.51
5.64
1.83
0.37R
(TYP)
0.59
6.00
6.90
-204
S 79715.17 (BH1)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 17 OF 57)

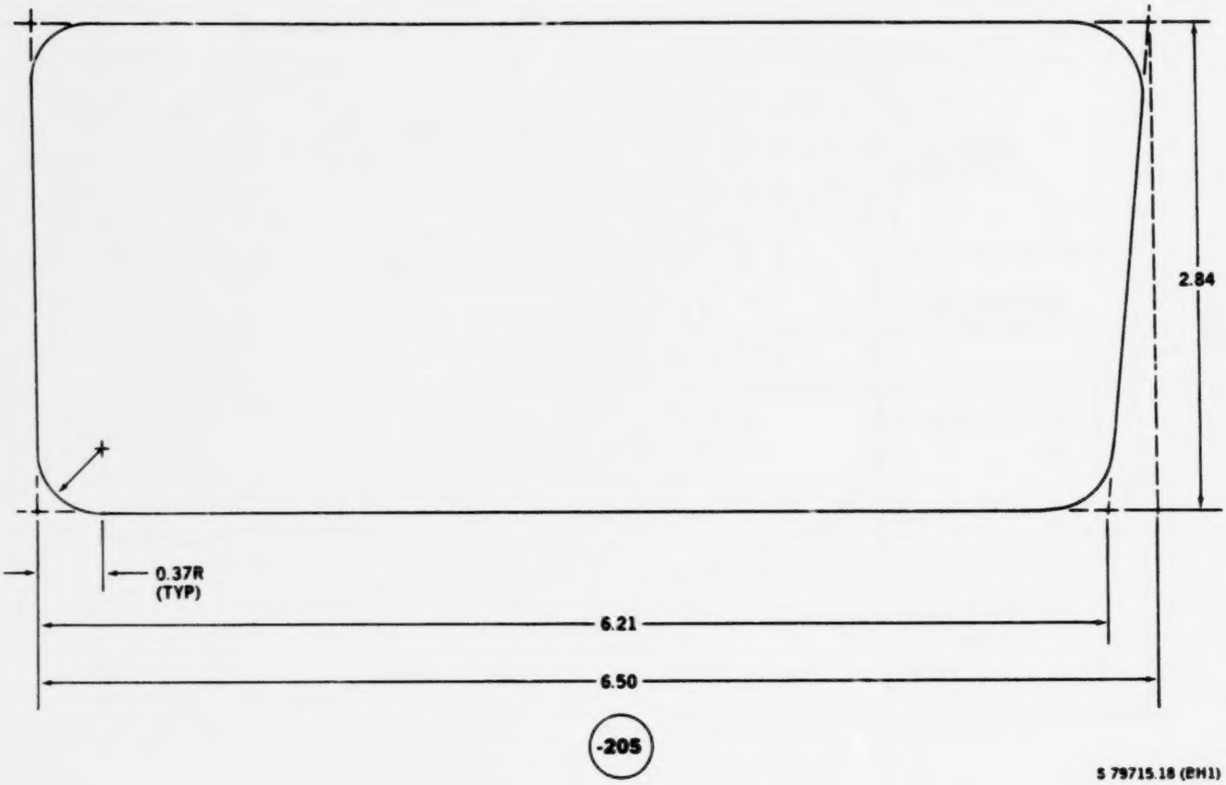

2.84
0.37R
(TYP)
6.21
6.50
-205
S 79715.18 (EH1)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 18 OF 57)

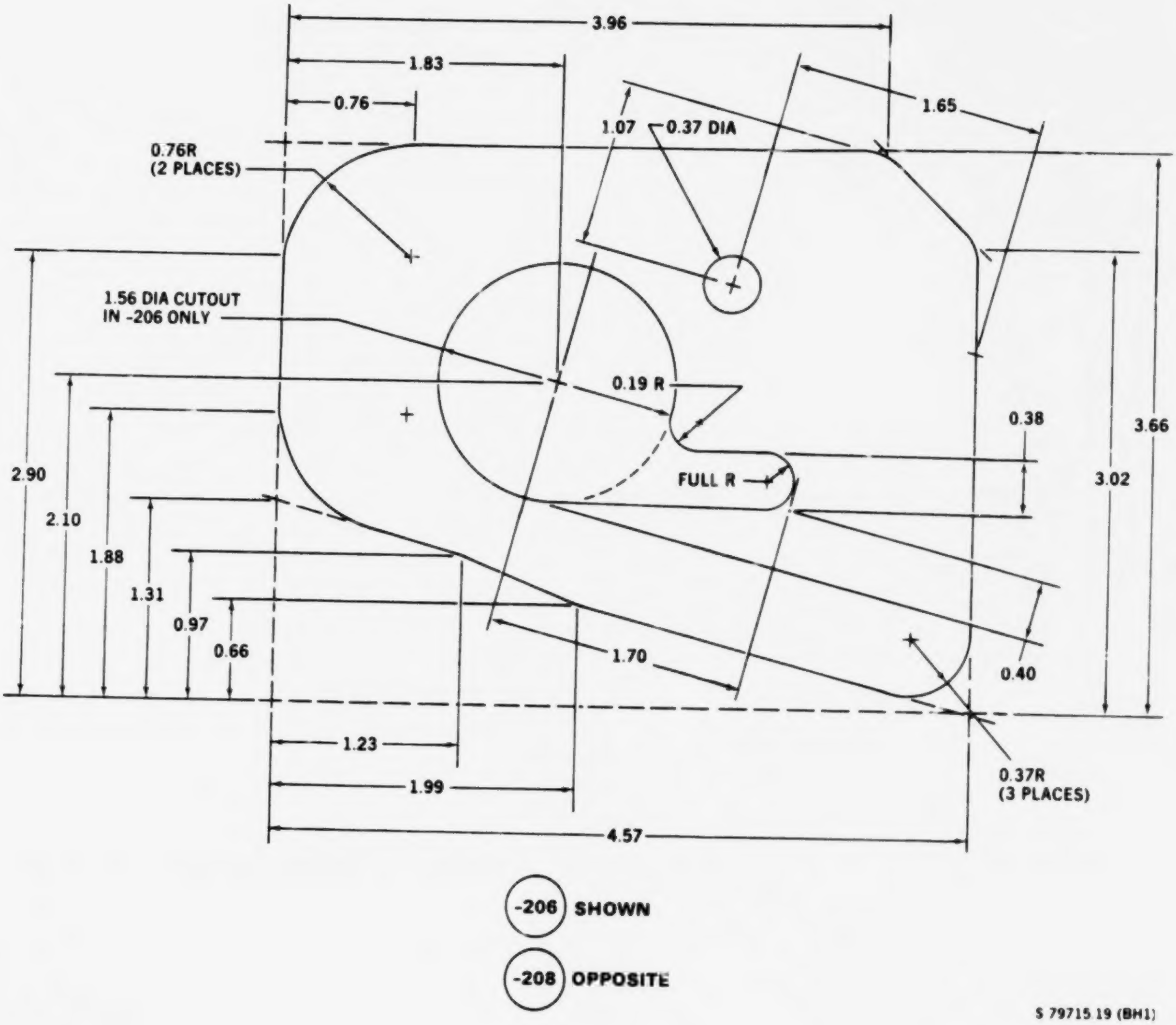
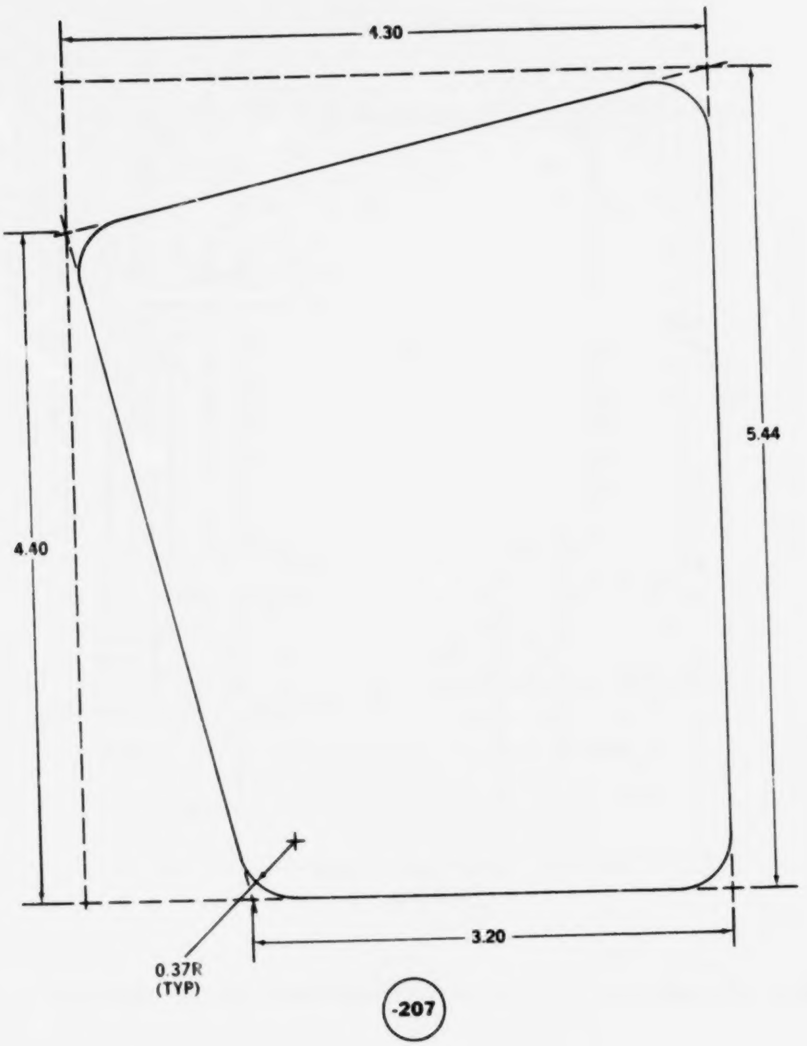
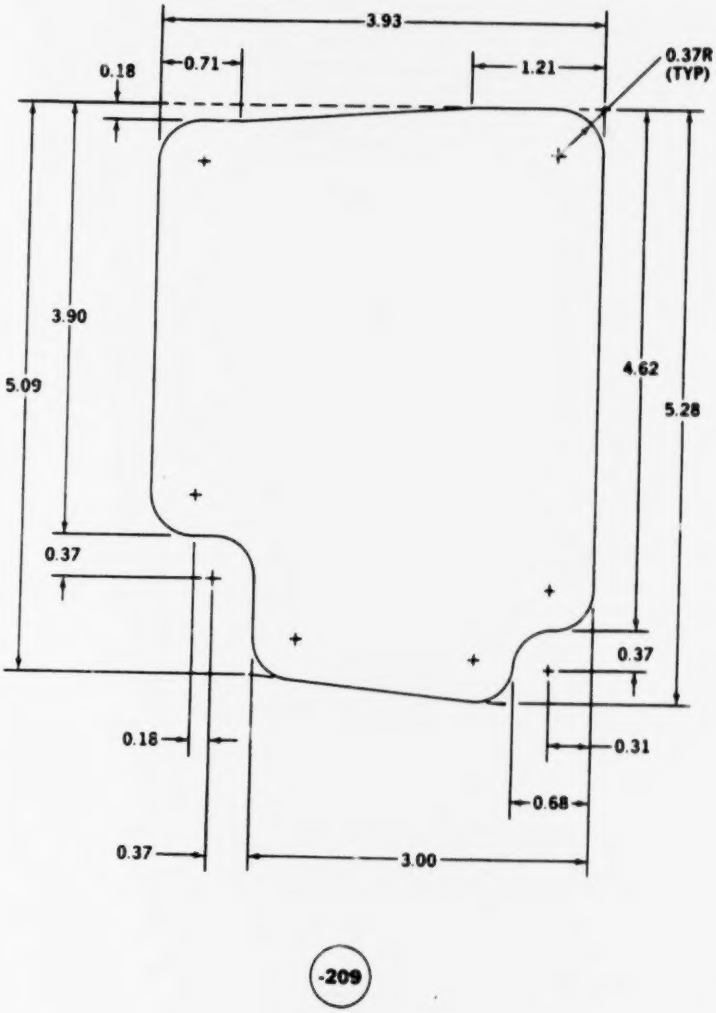

3.96
1.83
0.76
1.07
0.37 DIA
1.65
0.76R
(2 PLACES)
1.56 DIA CUTOUT
IN -206 ONLY
0.19 R
0.38
3.66
3.02
FULL R
2.90
2.10
1.88
1.31
0.97
0.66
1.70
0.40
1.23
1.99
4.57
0.37R
(3 PLACES)
-206 SHOWN
-208 OPPOSITE
S 79715 19 (BH1)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 19 OF 57)


4.30
5.44
4.40
3.20
0.37R
(TYP)
-207

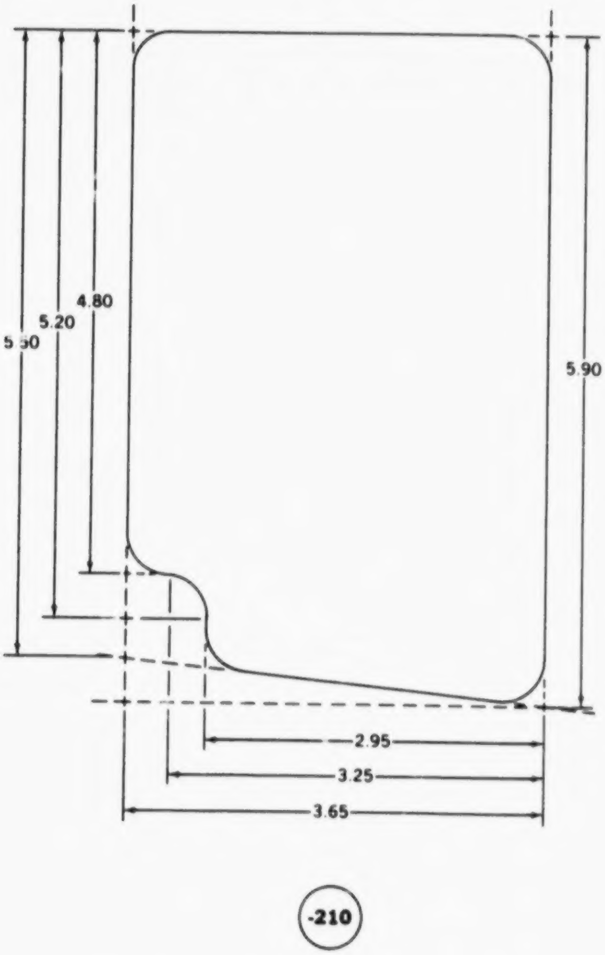
S 79715.20 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 20 OF 57)


3.93
0.71
1.21
0.18
0.37R
(TYP)
3.90
5.09
4.62
5.28
0.37
0.37
0.18
0.31
0.68
0.37
3.00
-209

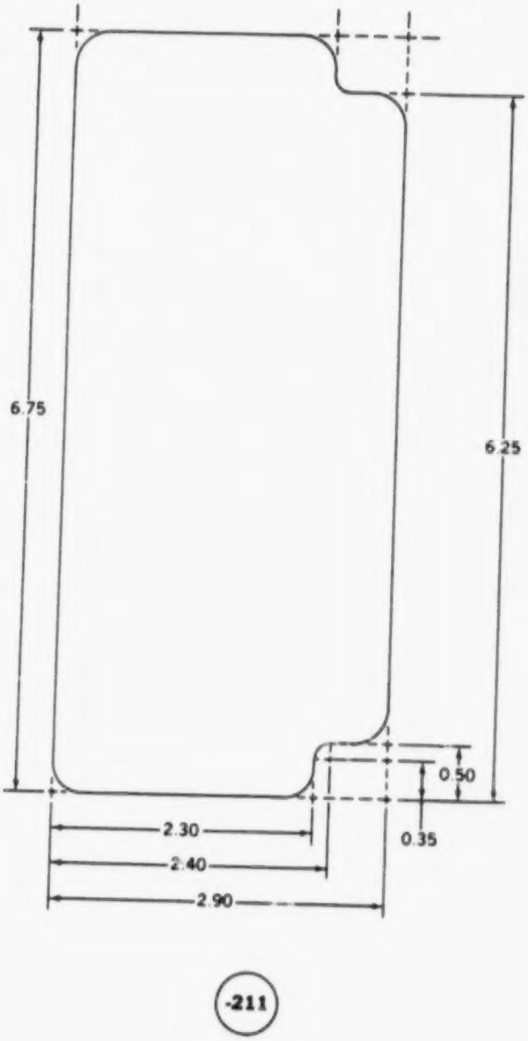
S 79715.21 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 21 OF 57)


4.80
5.20
5.50
5.90
2.95
3.25
3.65
-210

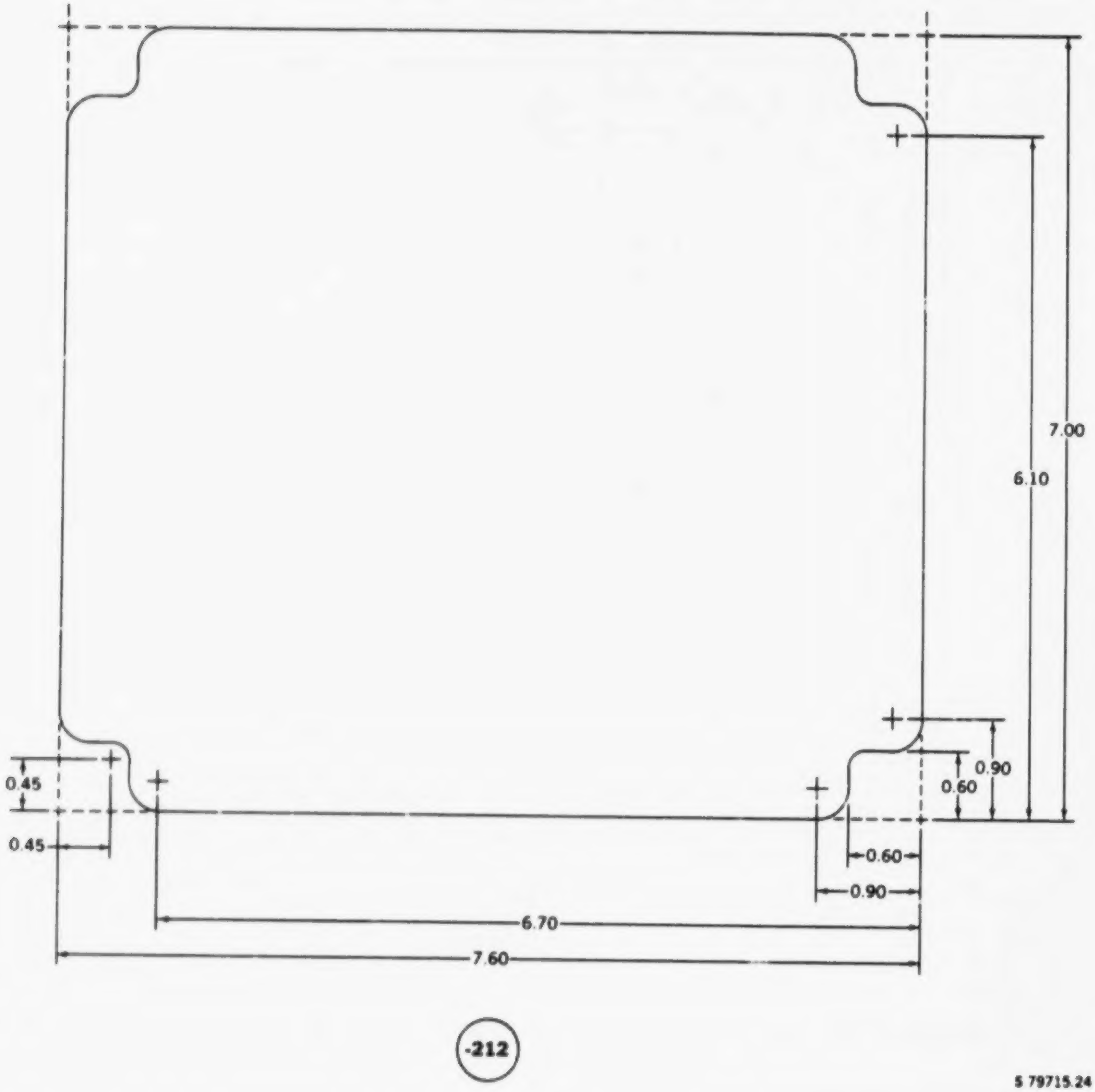
S 79715.22 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 22 OF 57)


6.75
6.25
0.50
0.35
2.30
2.40
2.90
-211

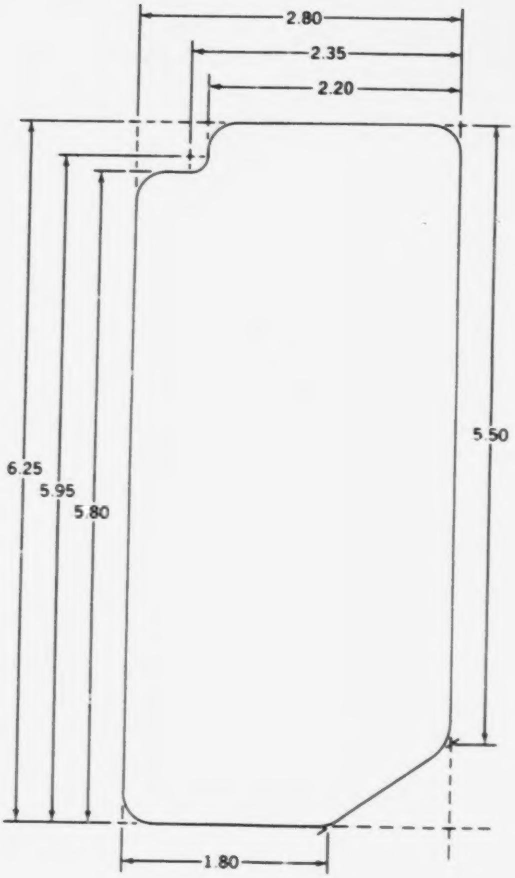
S 79 /5.23 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 23 OF 57)


7.00
6.10
0.90
0.60
0.45
0.45
0.60
0.90
6.70
7.60
-212

S 79715.24 (C18)

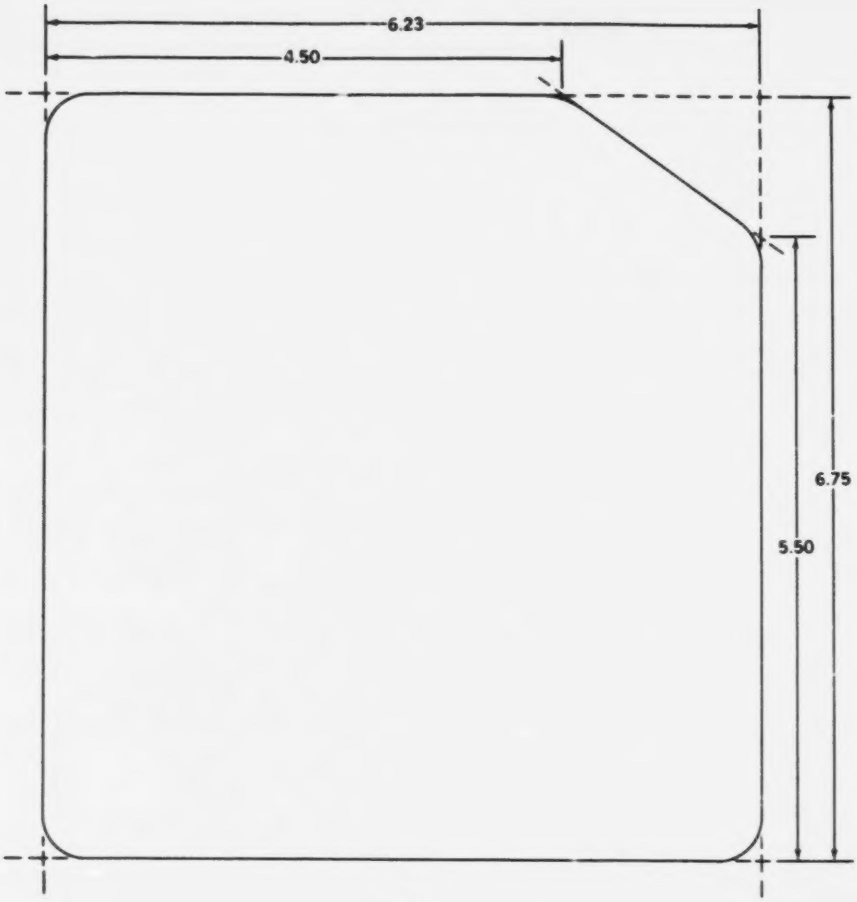
FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 24 OF 57)


2.80
2.35
2.20
6.25
5.95
5.80
5.50
1.80

-213

S 75715.25 (C18)

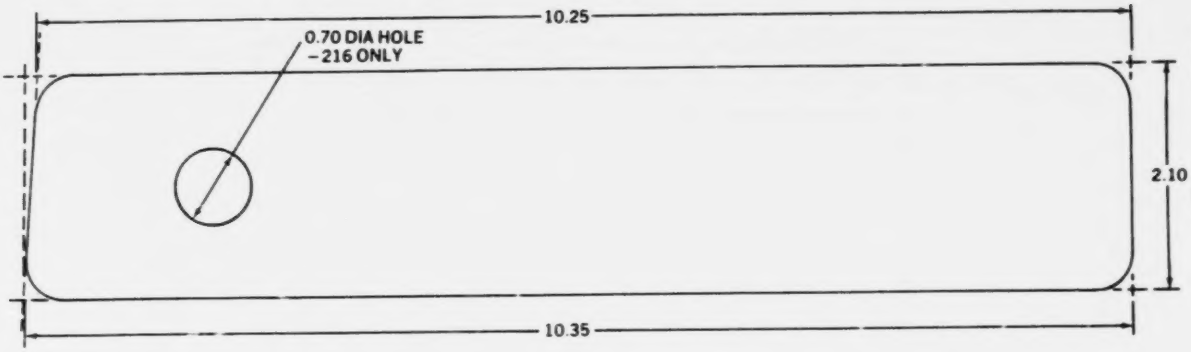
FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 25 OF 57)


6.23
4.50
6.75
5.50

-215

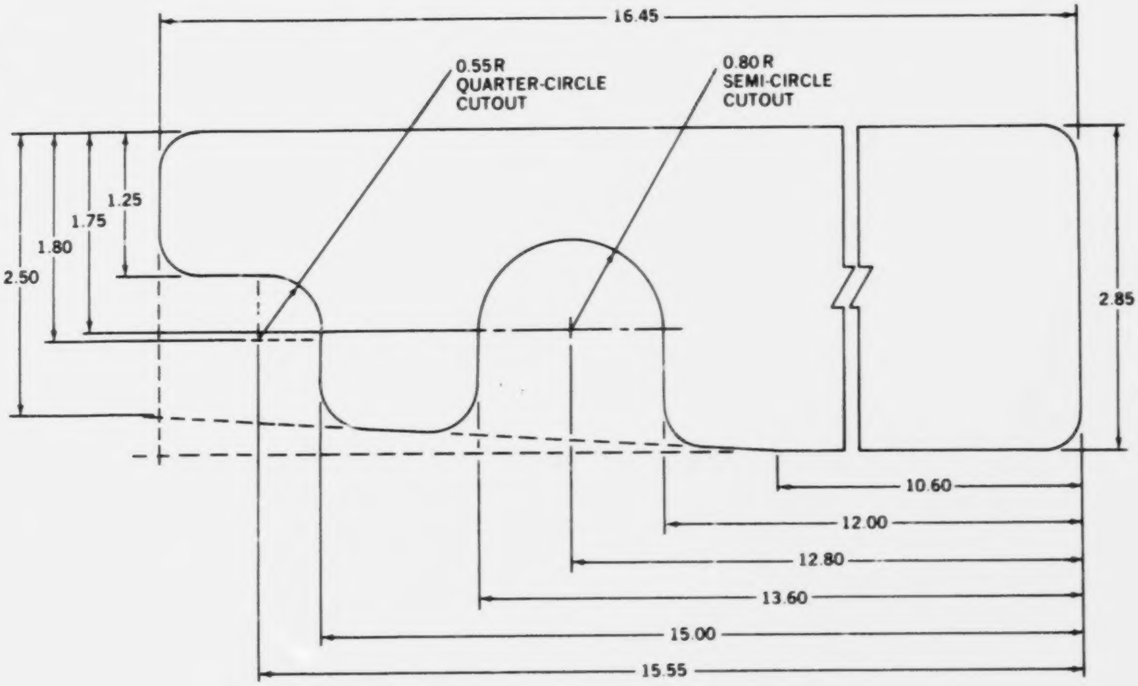
S 79715.26 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 26 OF 57)


10.25
0.70 DIA HOLE
–216 ONLY
2.10
10.35

-216 **SHOWN**

-217 **OPPOSITE**

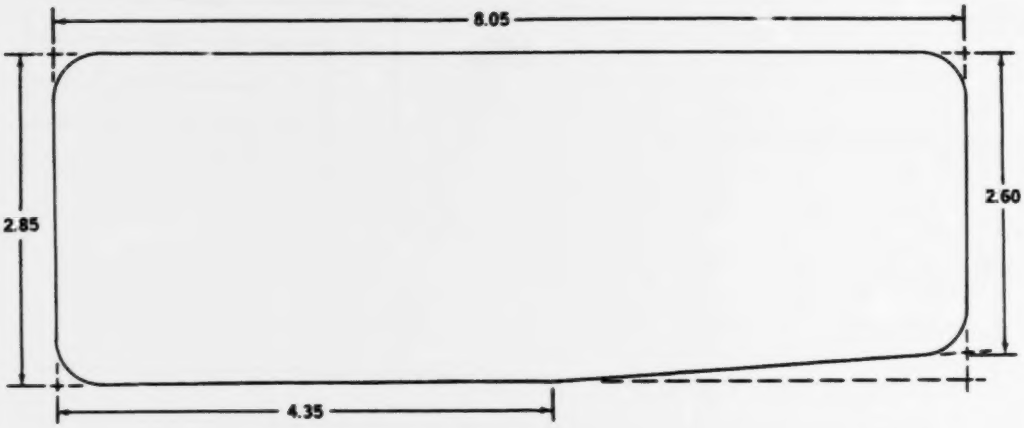

16.45
0.55 R
QUARTER-CIRCLE
CUTOUT
0.80 R
SEMI-CIRCLE
CUTOUT
1.25
1.75
1.80
2.50
2.85
10.60
12.00
12.80
13.60
15.00
15.55

-222 **SHOWN**

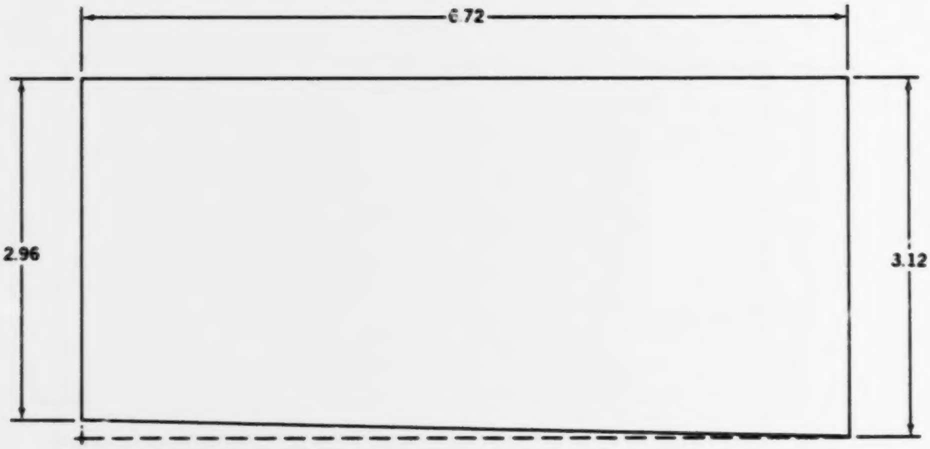
-268 **OPPOSITE**

S 79715.27 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 27 OF 57)


8.05
2.85
2.60
4.35

-224

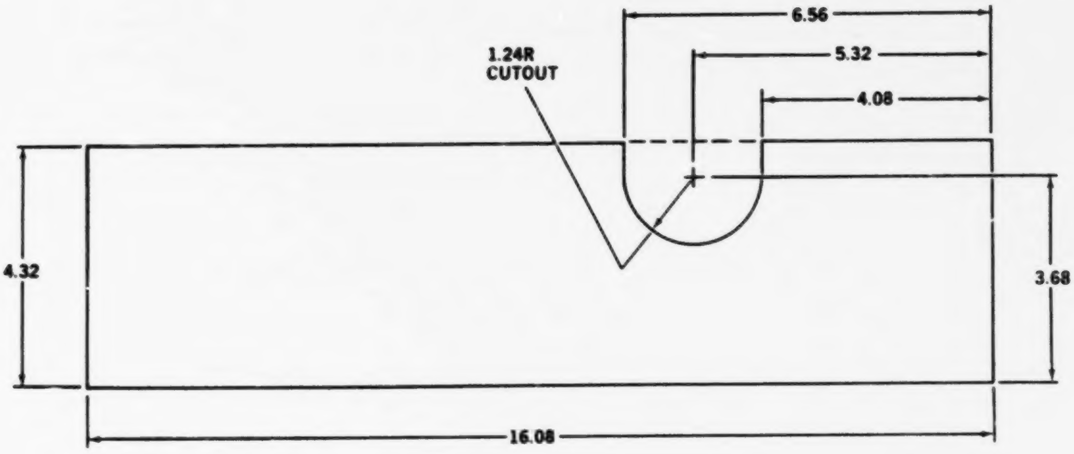


-231 SHOWN

-232 OPPOSITE

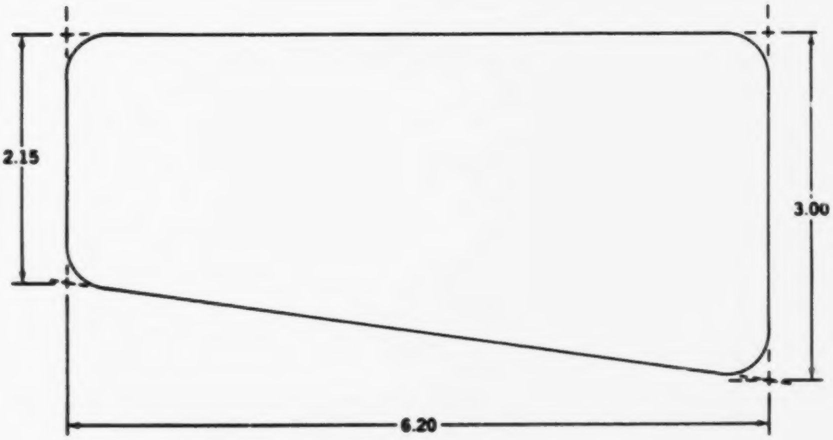
S 79715.28 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 28 OF 57)


6.56
5.32
4.08
1.24R
CUTOUT
4.32
3.68
16.08

-236 SHOWN

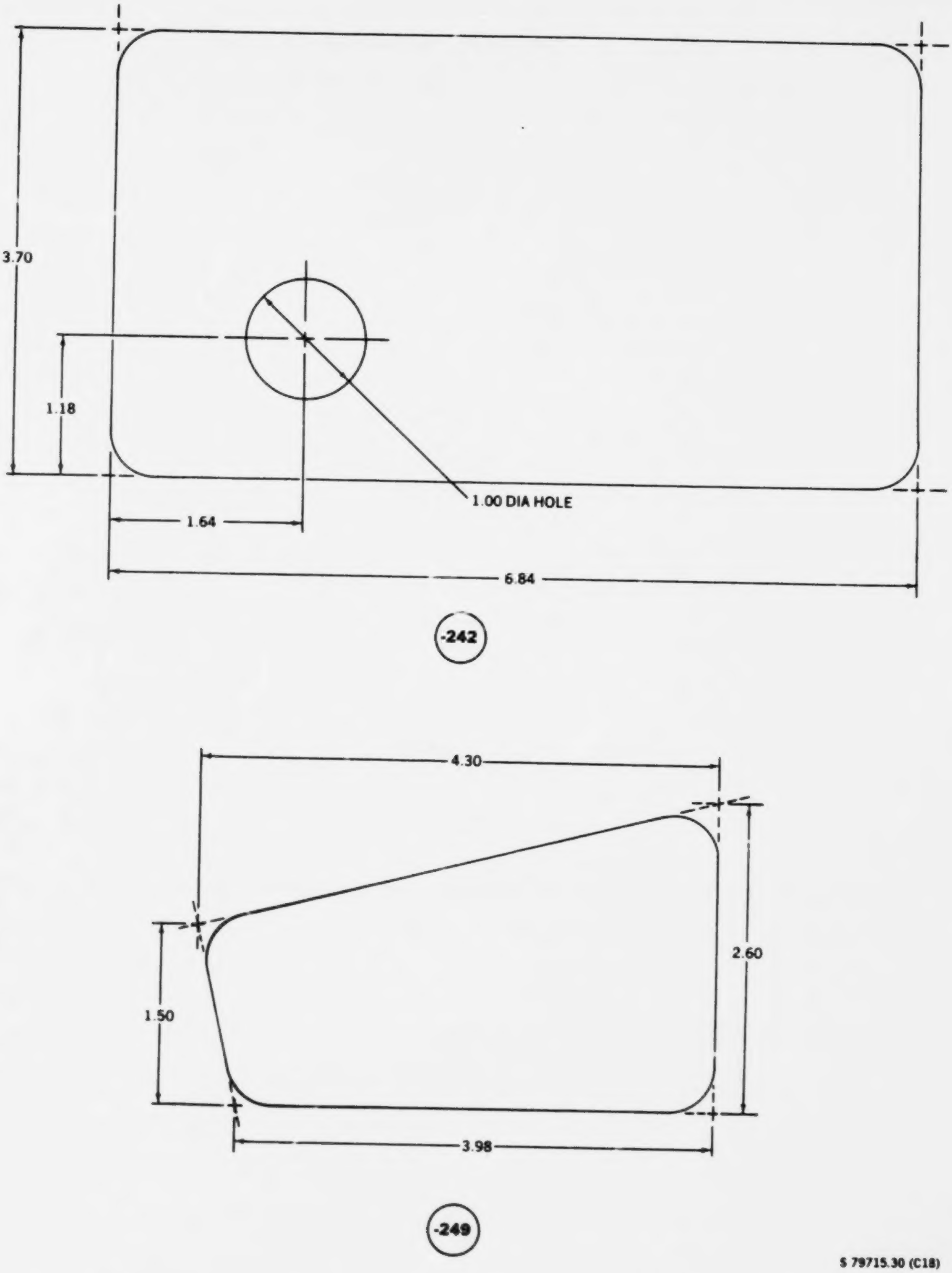
-237 OPPOSITE



-240

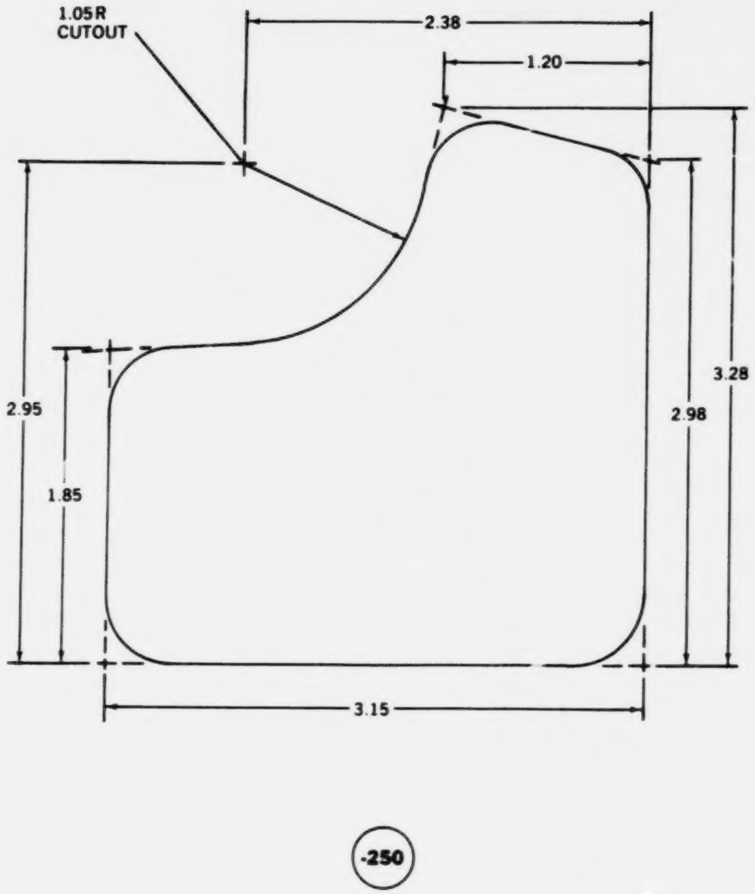
S 79715.29 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 29 OF 57)


3.70
1.18
1.64
6.84
1.00 DIA HOLE
-242
4.30
2.60
1.50
3.98
-249

S 79715.30 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 30 OF 57)


1.05R CUTOUT
2.38
1.20
3.28
2.98
2.95
1.85
3.15
-250

S 79715.31 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 31 OF 57)

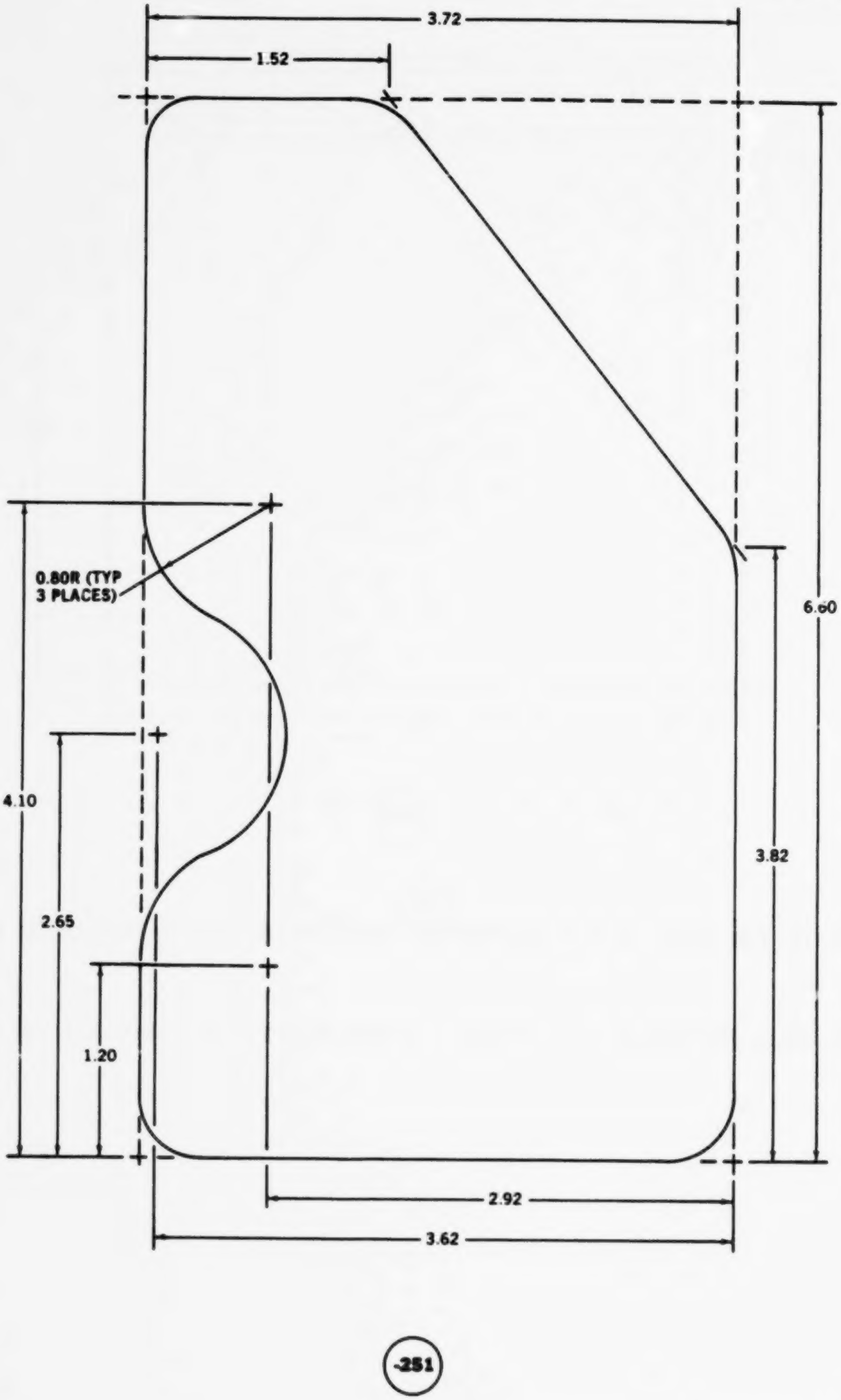
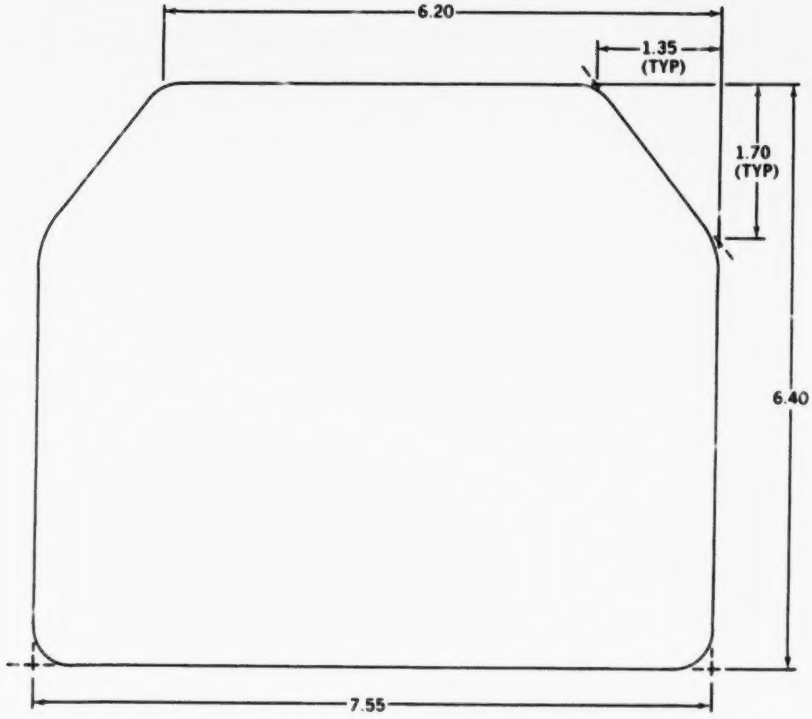

3.72
1.52
0.80R (TYP 3 PLACES)
6.60
4.10
3.82
2.65
1.20
2.92
3.62
251
S 79715.32 (C18)

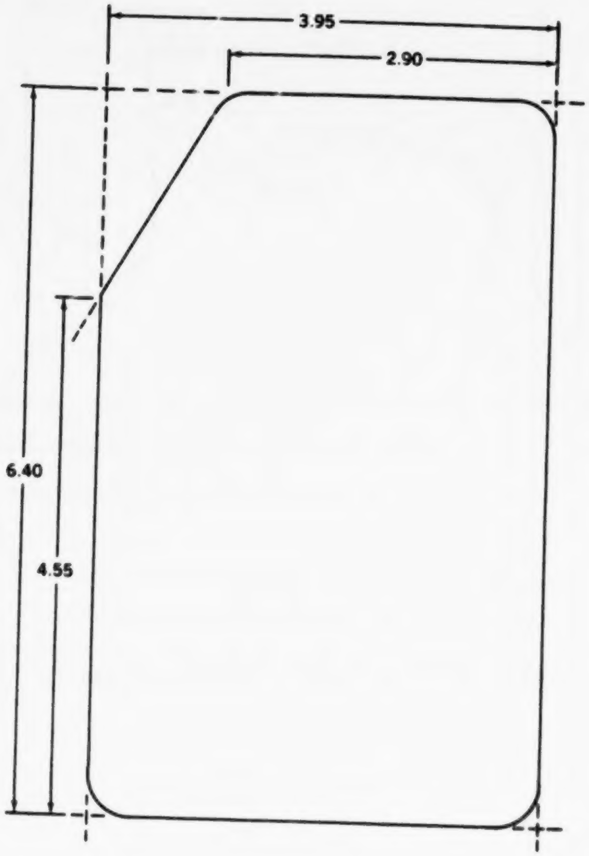
FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 32 OF 57)


6.20
1.35 (TYP)
1.70 (TYP)
6.40
7.55

-252

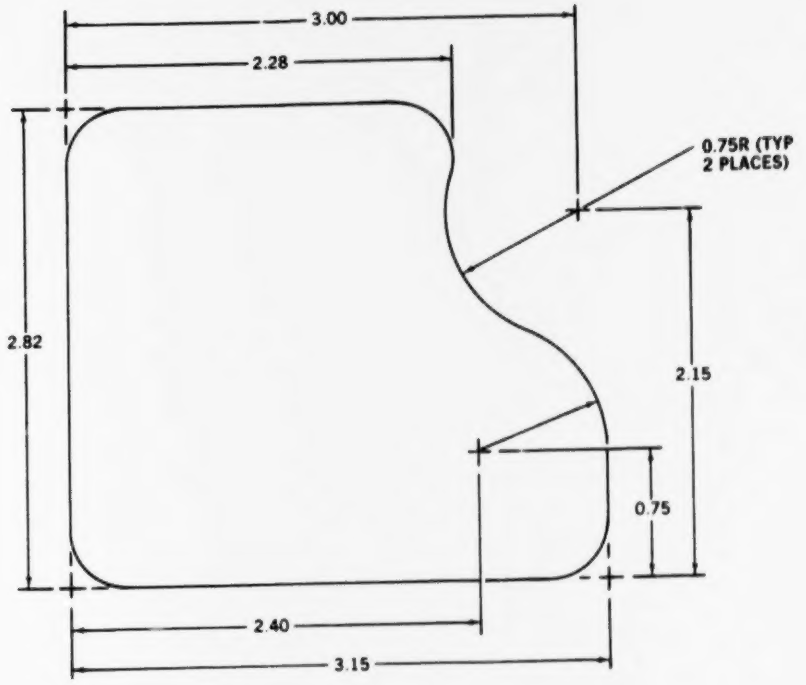
S 79715.33 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 33 OF 57)


3.95
2.90
6.40
4.55

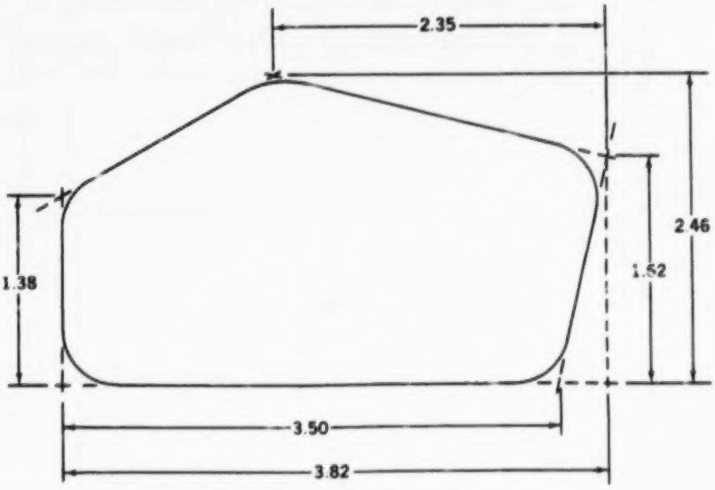
S 79715.34 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 34 OF 57)


3.00
2.28
0.75R (TYP 2 PLACES)
2.82
2.15
0.75
2.40
3.15

S 79715.35 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 35 OF 57)

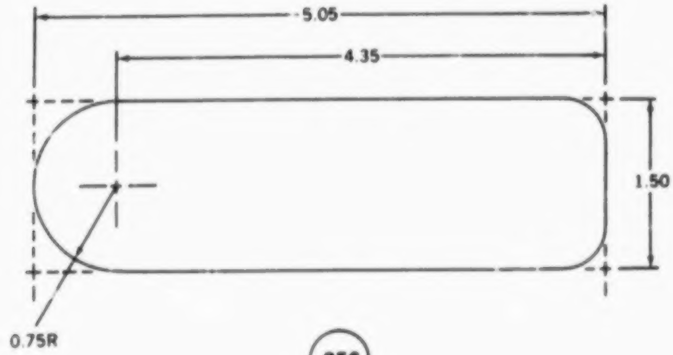


2.35
2.46
1.62
1.38
3.50
3.82

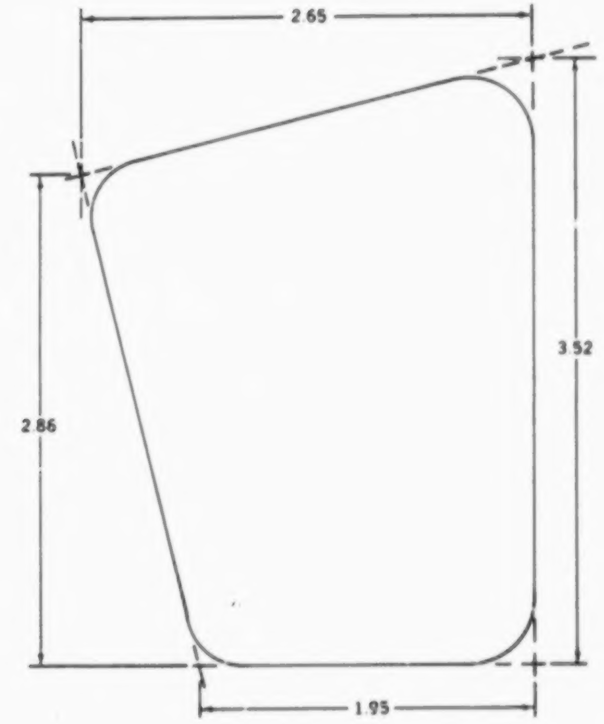
-255

S 79715 36 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 36 OF 57)


5.05
4.35
1.50
0.75R

-256

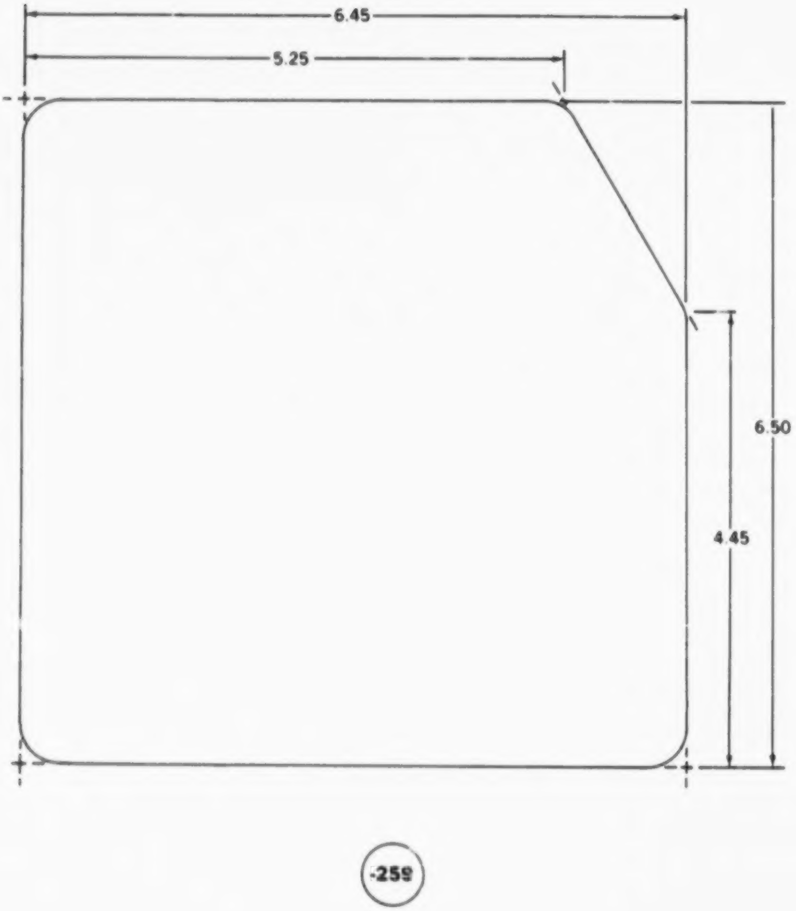

2.65
3.52
2.86
1.95

-257 **SHOWN**

-264 **OPPOSITE**

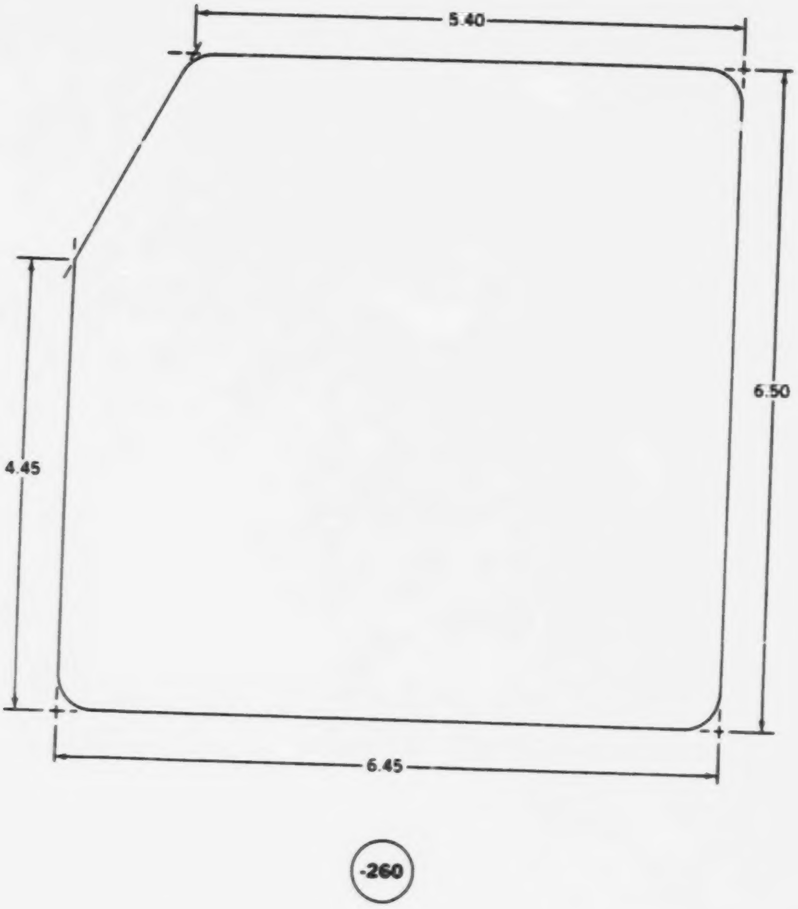
S 79715.37 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 37 OF 57)


6.45
5.25
6.50
4.45
-259

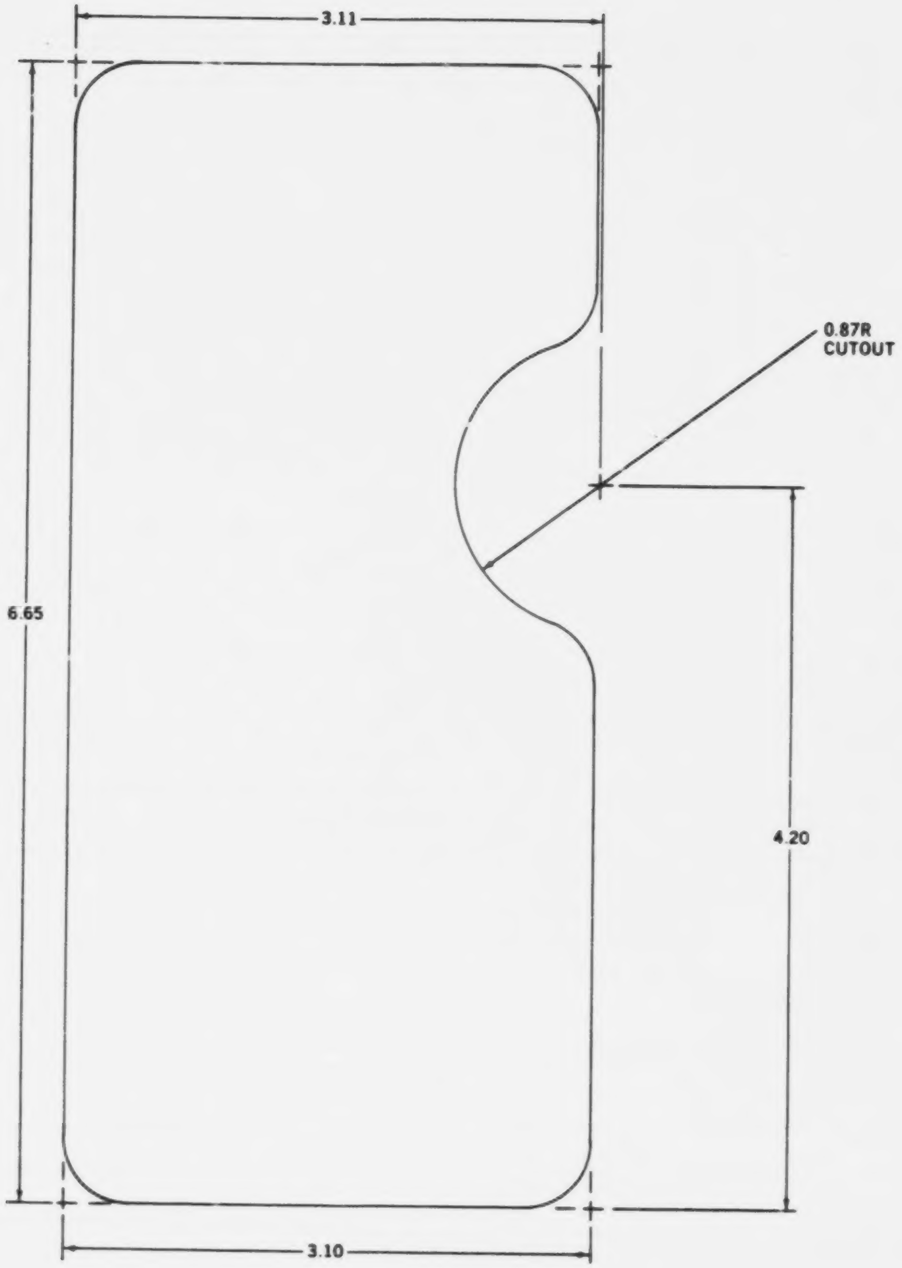
S 79715.38 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 38 OF 57)


5.40
6.50
4.45
6.45
-260

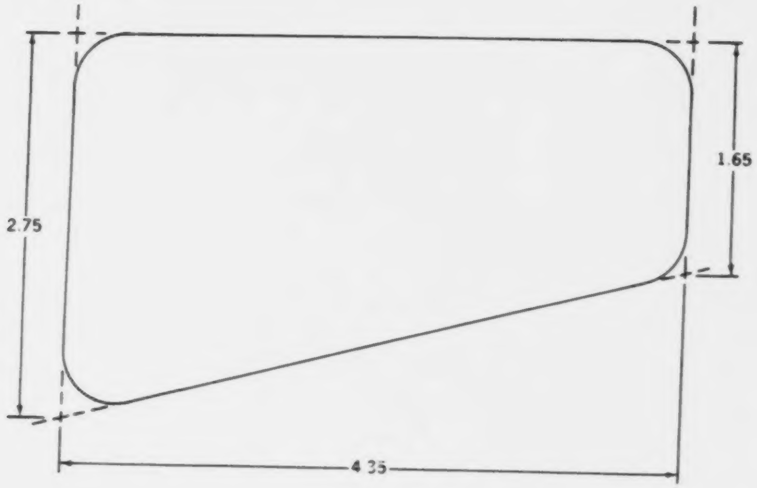
S 79715.39 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 39 OF 57)

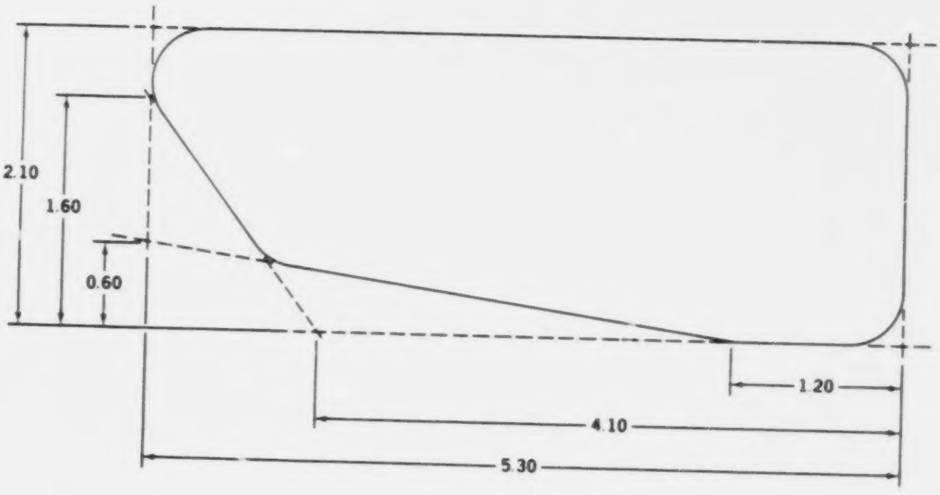

3.11
0.87R
CUTOUT
6.65
4.20
3.10

S 79715.40 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 40 OF 57)



-262

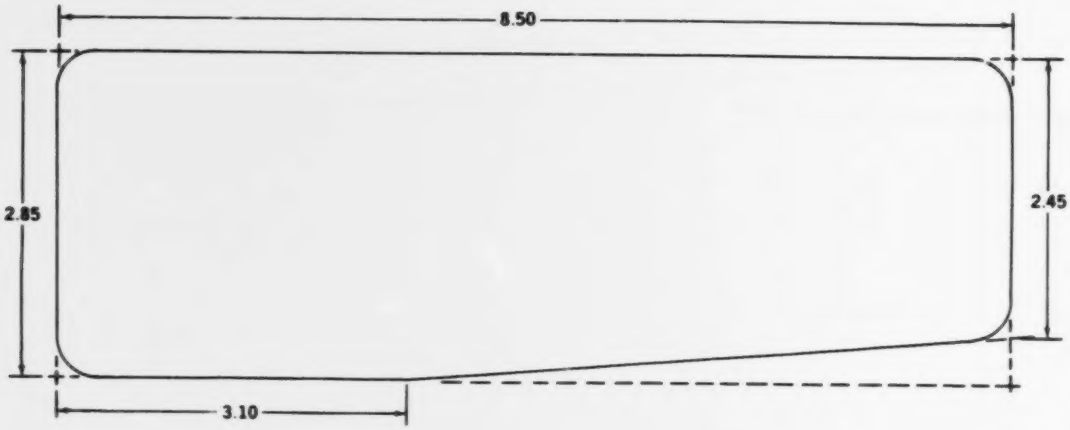

2.10
1.60
0.60
1.20
4.10
5.30

-269 **SHOWN**

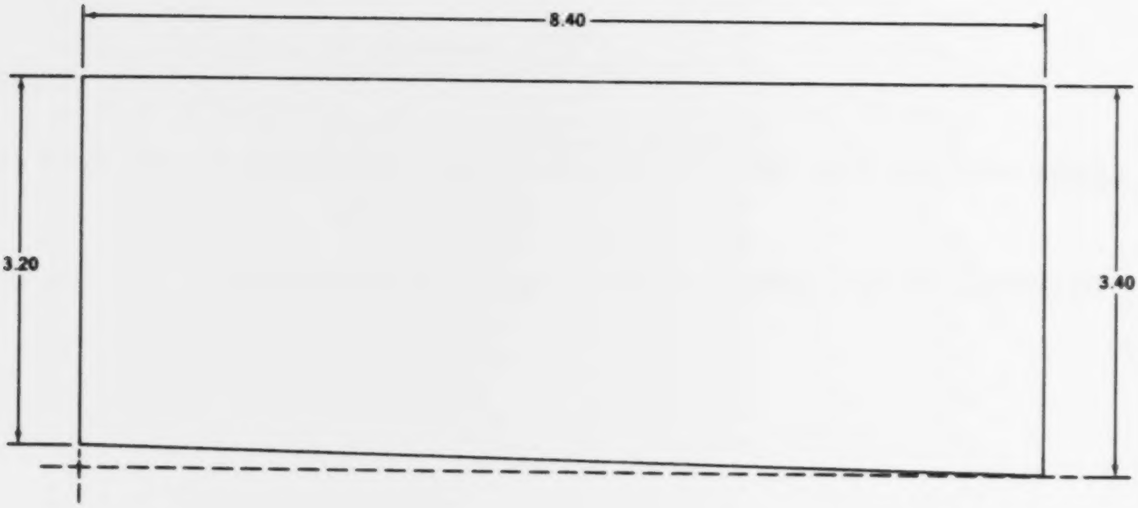
-270 **OPPOSITE**

S 79715.41 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 41 OF 57)


8.50
2.85
2.45
3.10

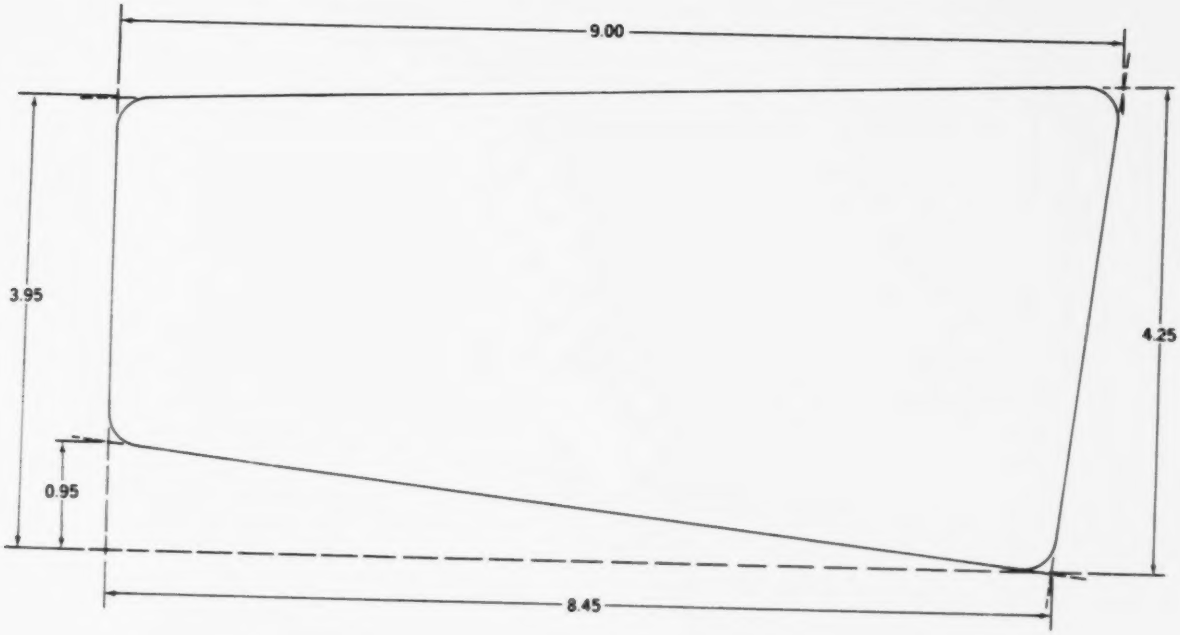
-271



-273

S 79715.42 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 42 OF 57)

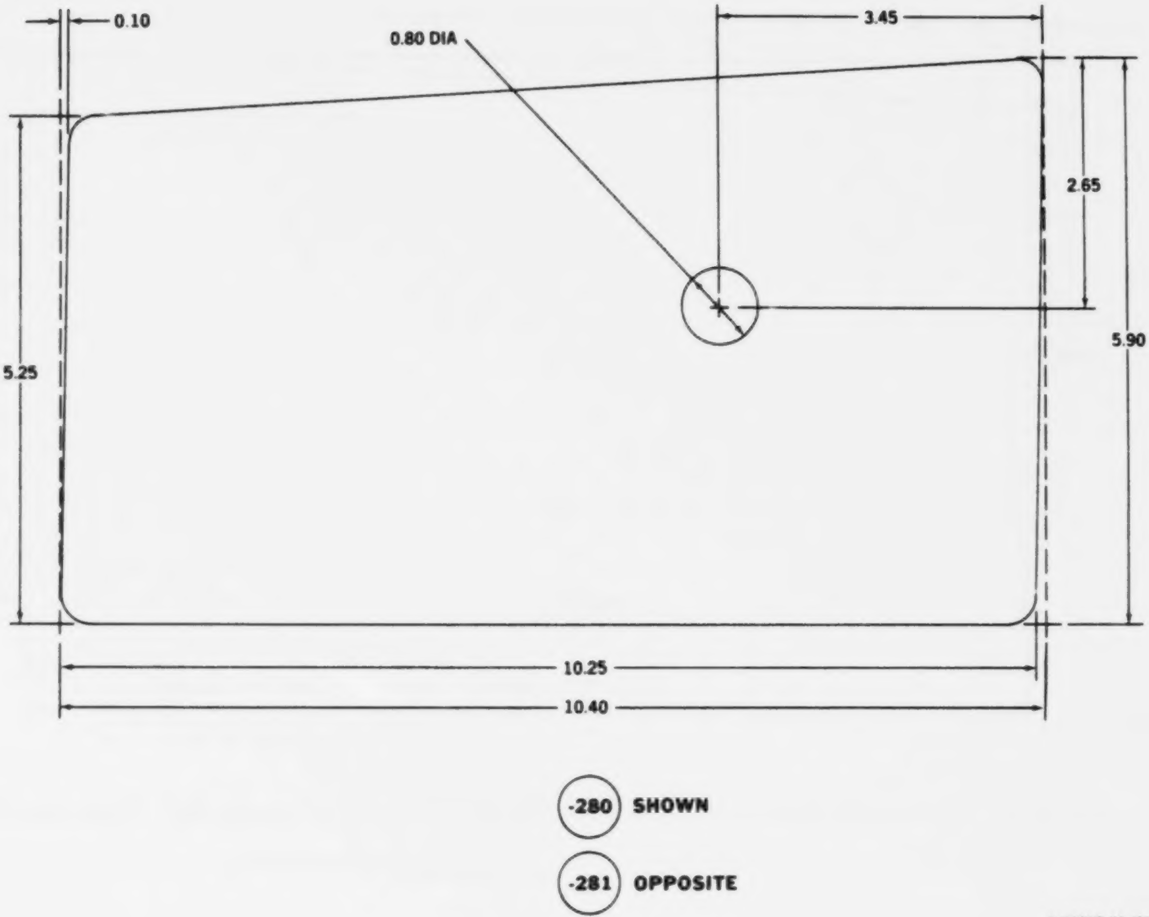

9.00
3.95
4.25
0.95
8.45

(-278) **SHOWN**

(-279) **OPPOSITE**

S 79715.43 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 43 OF 57)


0.10
0.80 DIA
3.45
2.65
5.90
5.25
10.25
10.40
-280 SHOWN
-281 OPPOSITE

S 79715.44 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 44 OF 57)

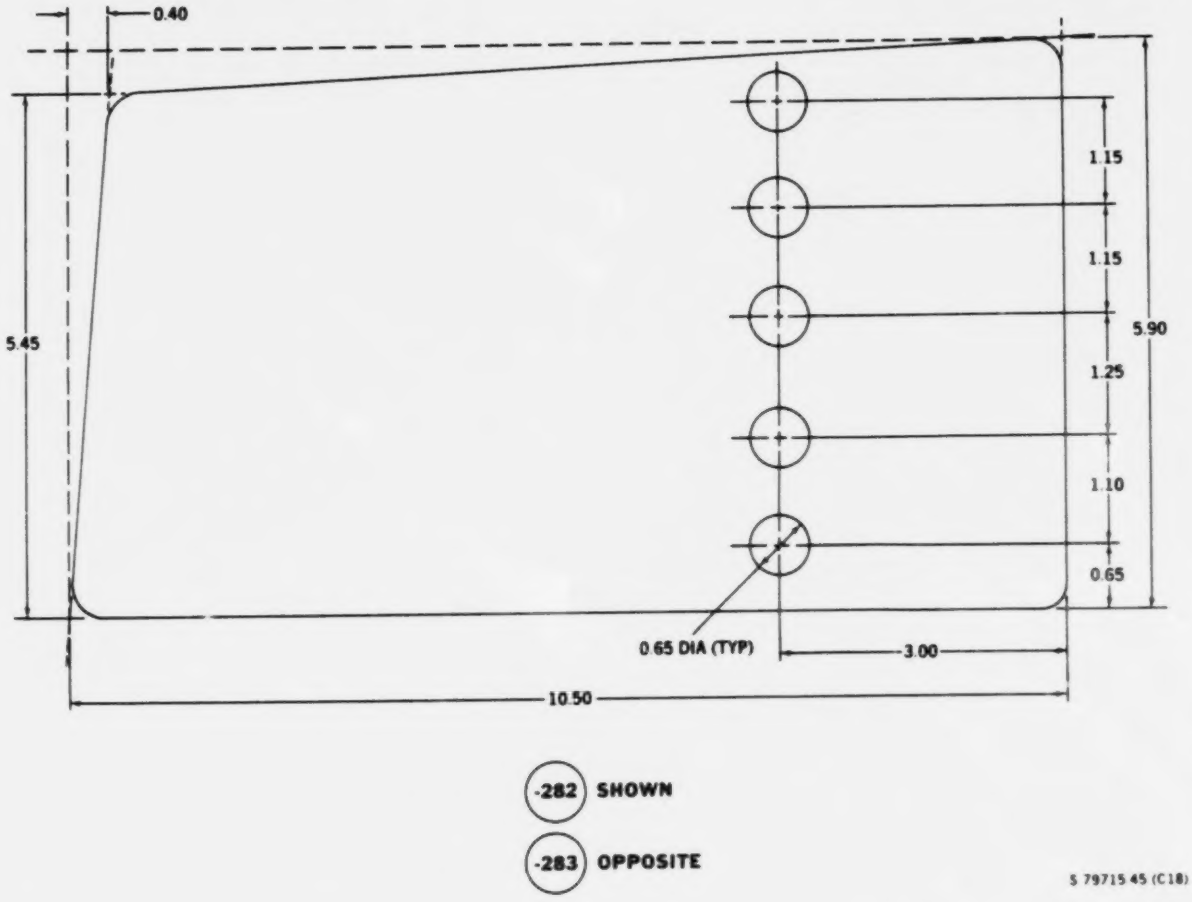
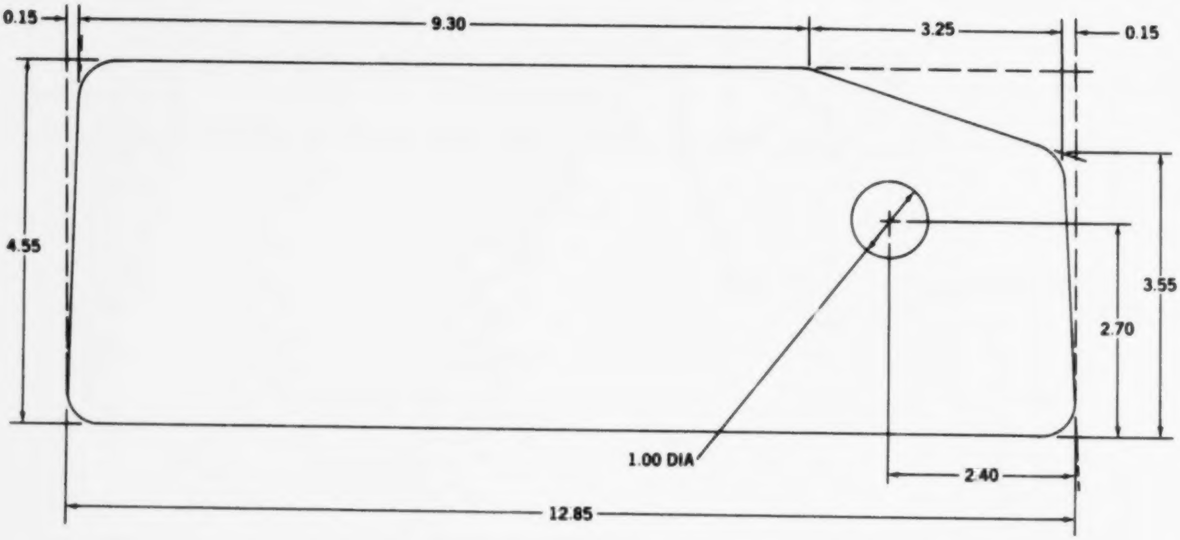

0.40
5.45
1.15
1.15
1.25
1.10
0.65
5.90
0.65 DIA (TYP)
3.00
10.50
-282 SHOWN
-283 OPPOSITE
S 79715 45 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 45 OF 57)

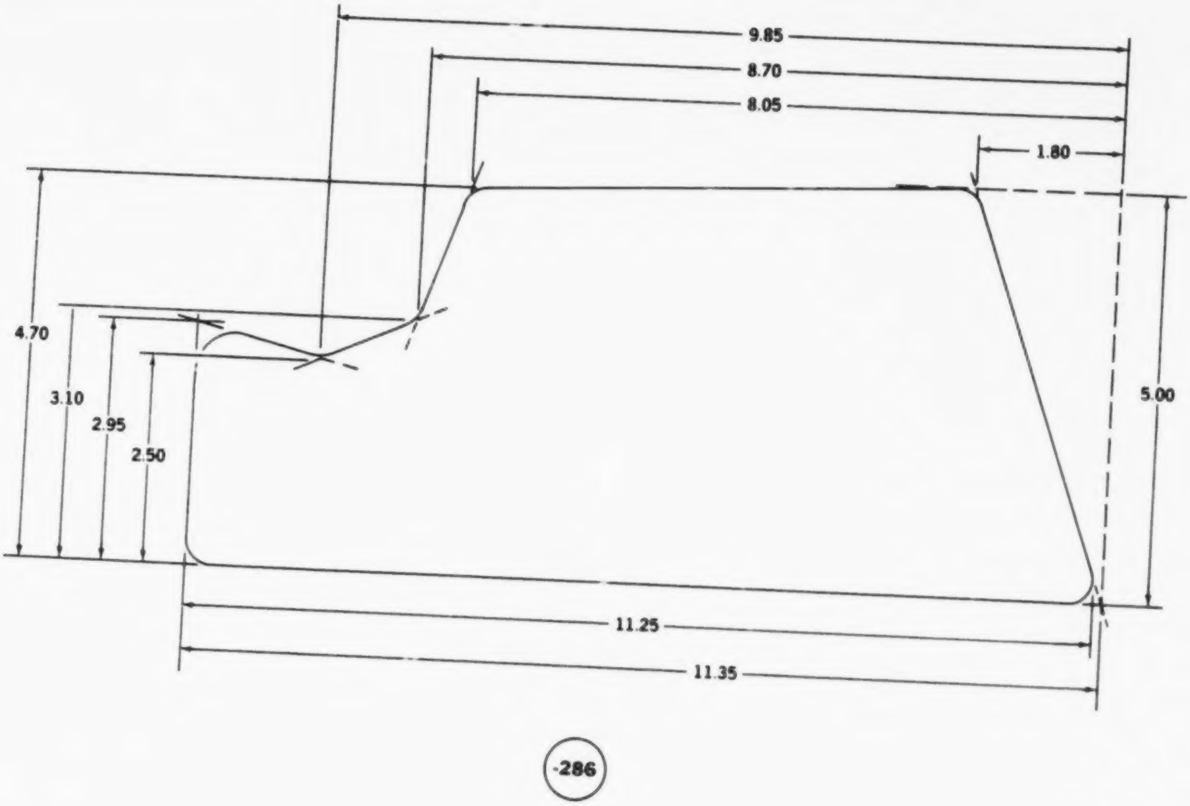

0.15
9.30
3.25
0.15
4.55
3.55
2.70
1.00 DIA
2.40
12.85

(-284) **SHOWN**

(-285) **OPPOSITE**

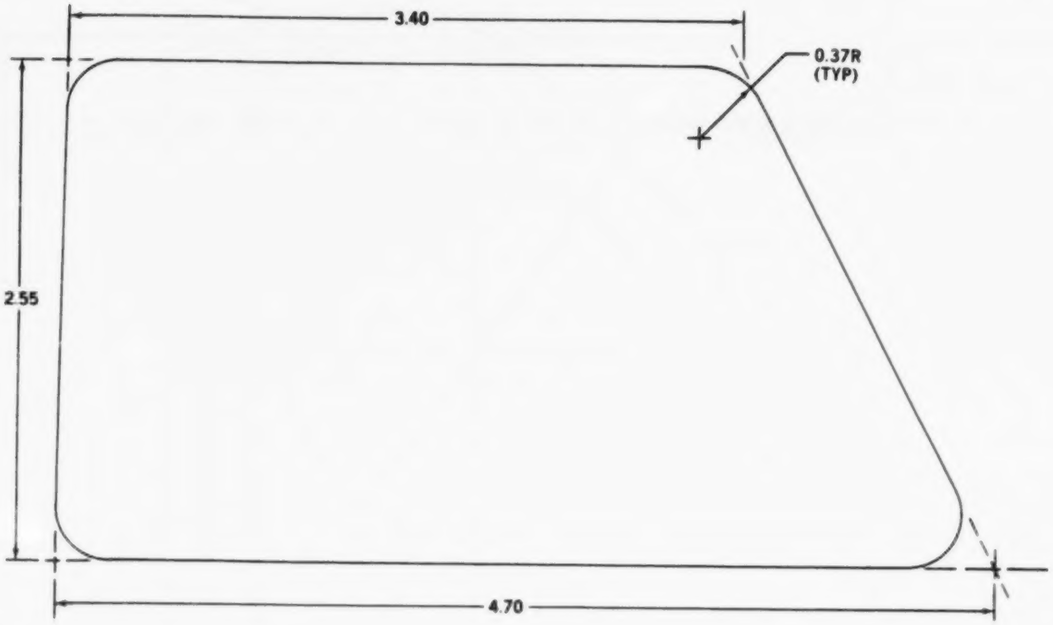
S 79715.46 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 46 OF 57)


9.85
8.70
8.05
1.80
4.70
3.10
2.95
2.50
5.00
11.25
11.35
-286

S 79715.47 (C18)

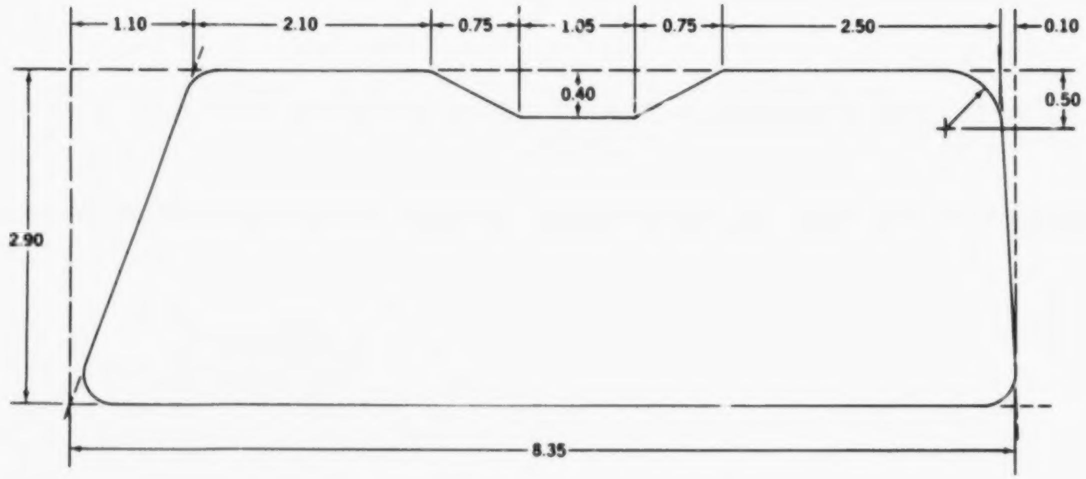
FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 47 OF 57)


3.40
0.37R
(TYP)
2.55
4.70

-287

S 79715.48 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 48 OF 57)


1.10
2.10
0.75
1.05
0.75
2.50
0.10
0.40
0.50
2.90
8.35

-288

S 79715.49 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 49 OF 57)

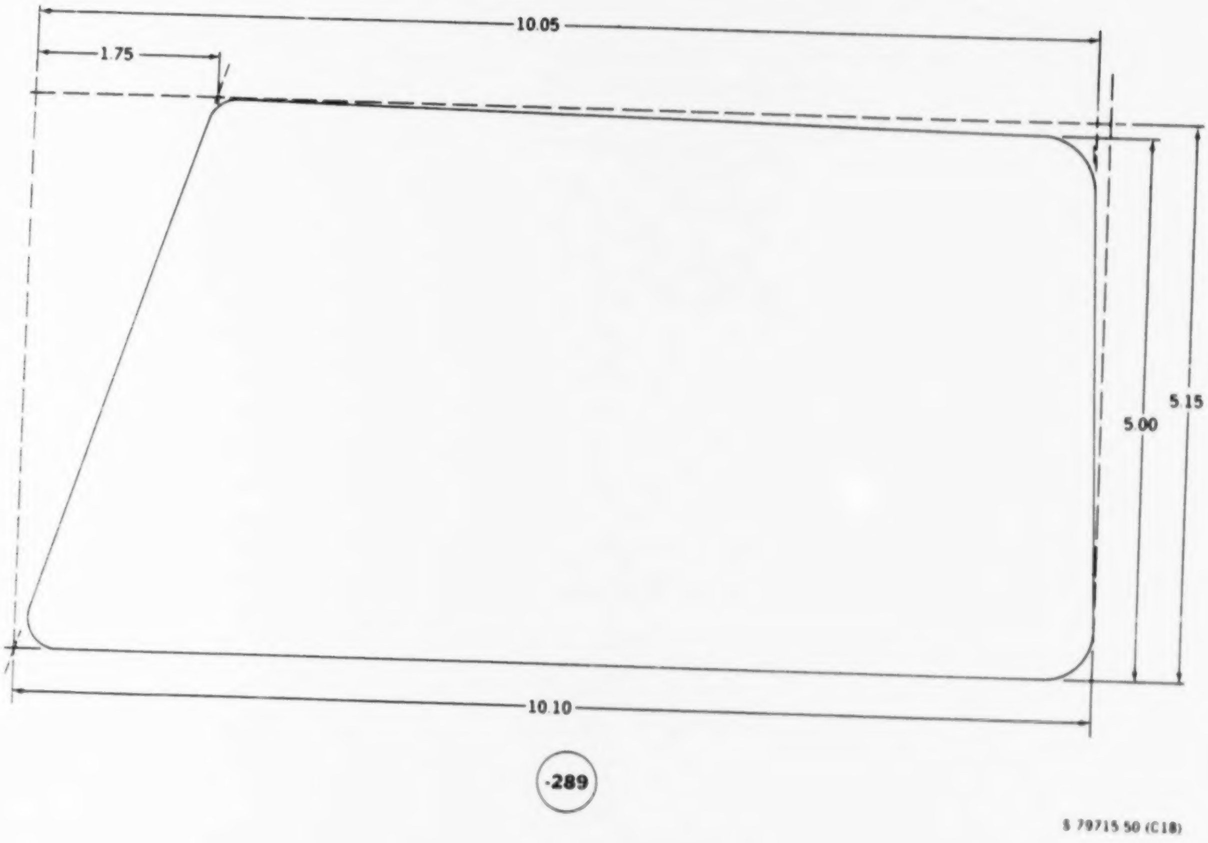
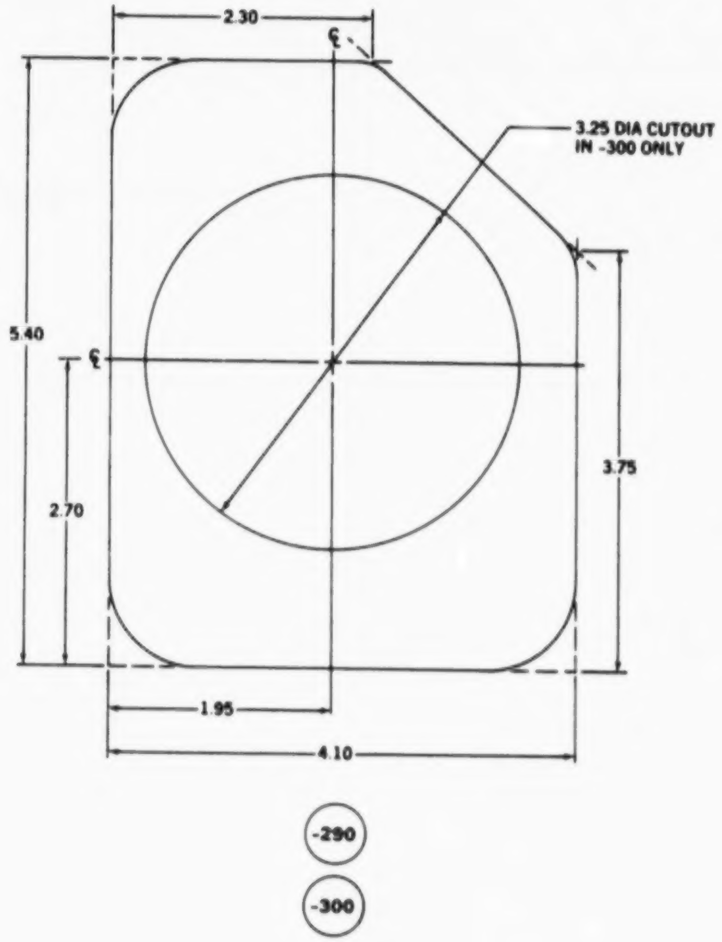
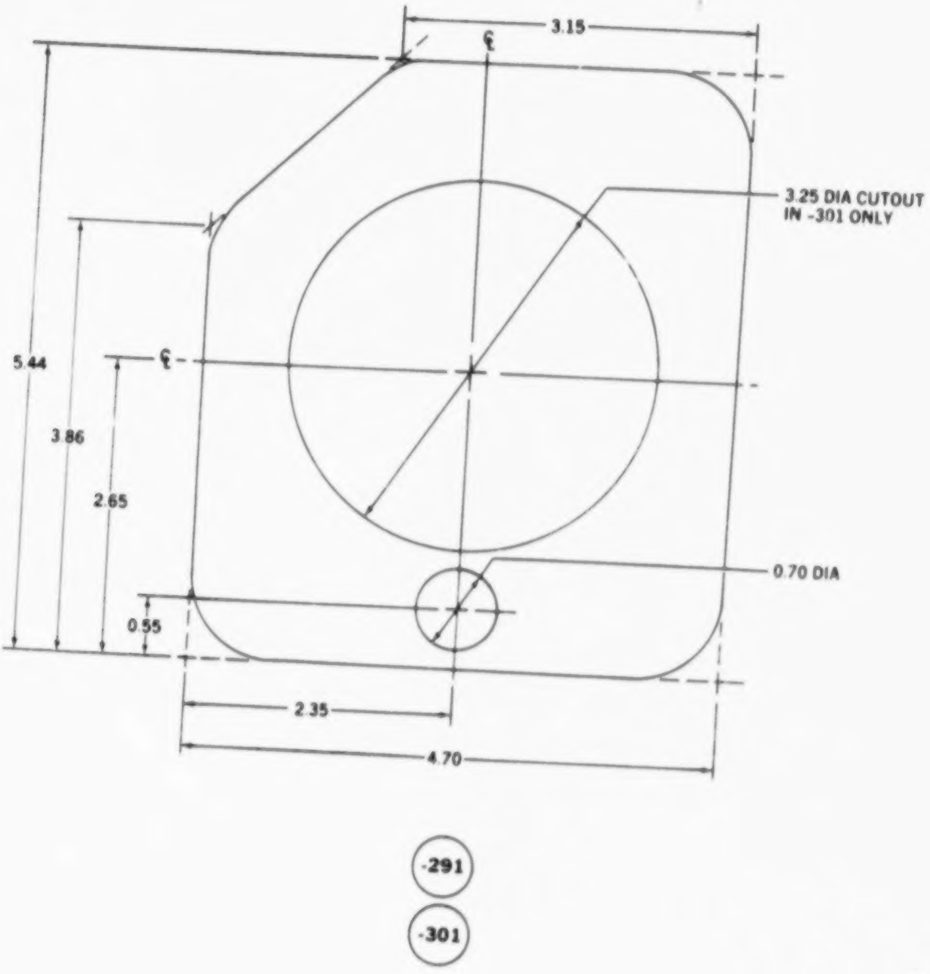

10.05
1.75
5.00
5.15
10.10
-289
S 79715 50 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 50 OF 57)


2.30
℄
3.25 DIA CUTOUT
IN -300 ONLY
5.40
℄
2.70
3.75
1.95
4.10
-290
-300

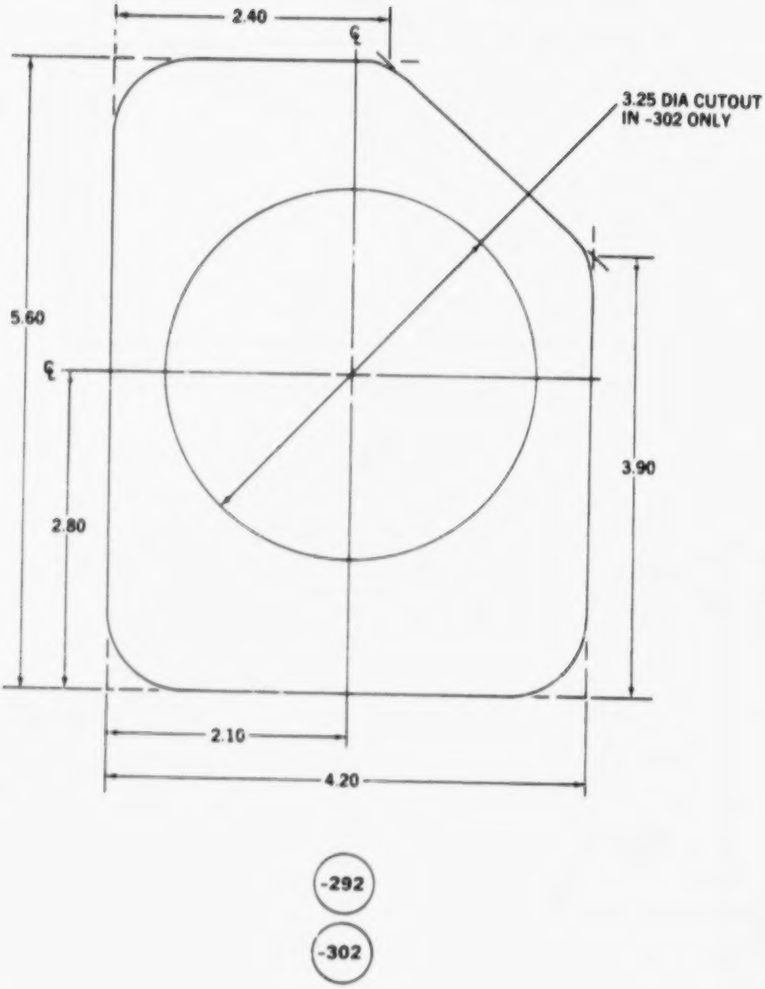
5 79715.51 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 51 OF 57)


3.15
℄
3.25 DIA CUTOUT
IN -301 ONLY
℄
5.44
3.86
2.65
0.55
0.70 DIA
2.35
4.70
-291
-301

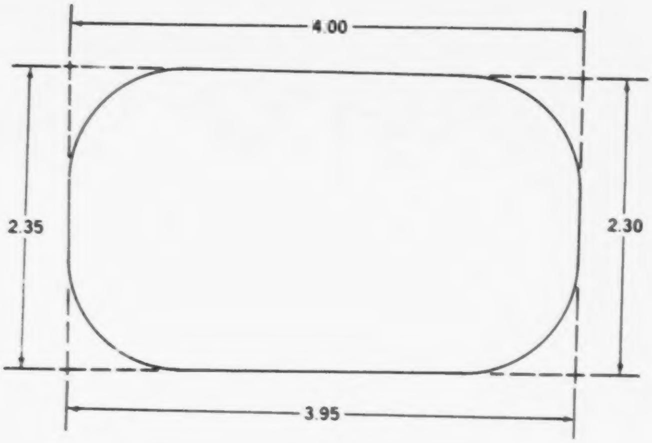
S 79715 52 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 52 OF 57)

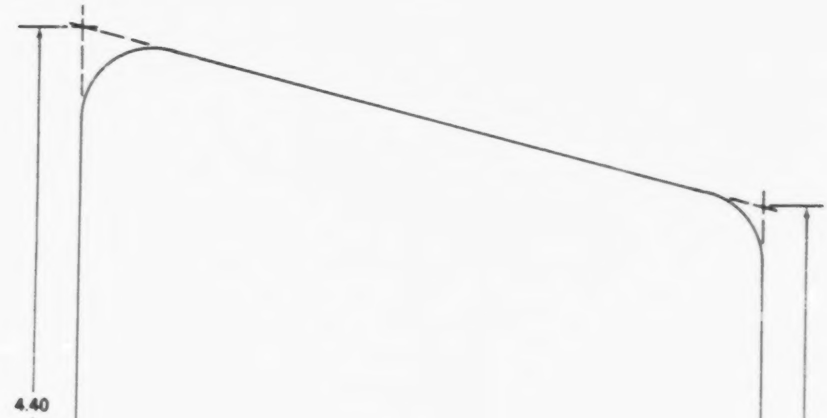

2.40
℄
3.25 DIA CUTOUT
IN -302 ONLY
5.60
℄
3.90
2.80
2.10
4.20
-292
-302

S 79715.53 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 53 OF 57)


4.00
2.35
2.30
3.95

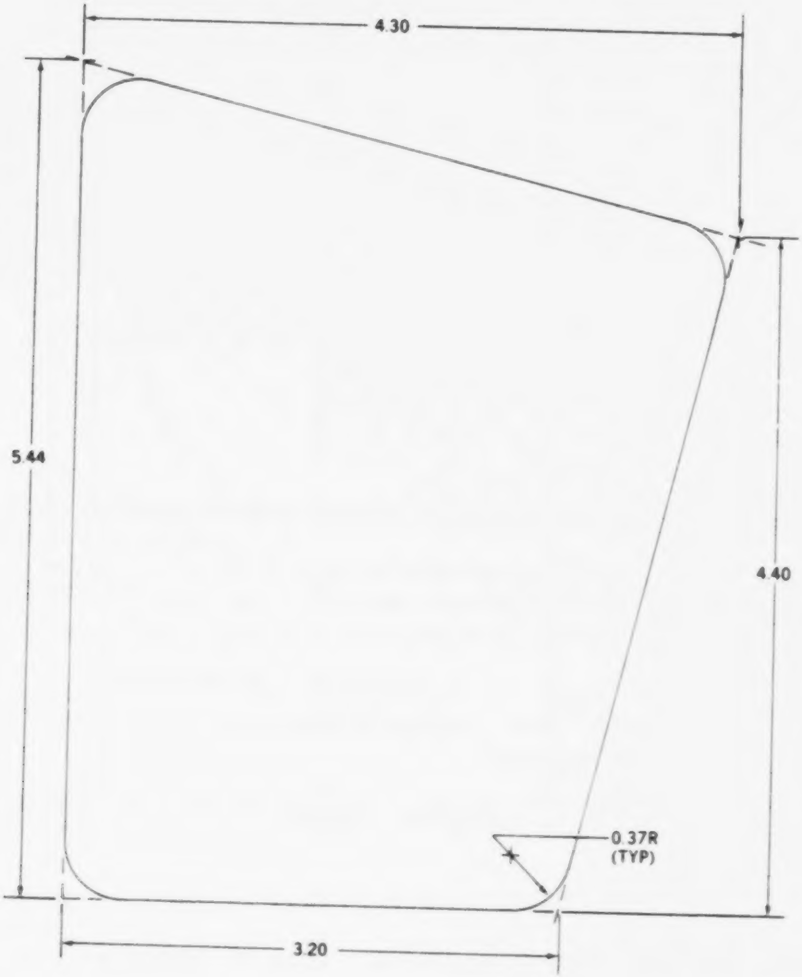
-293



-294

S 79715.54 (C18)

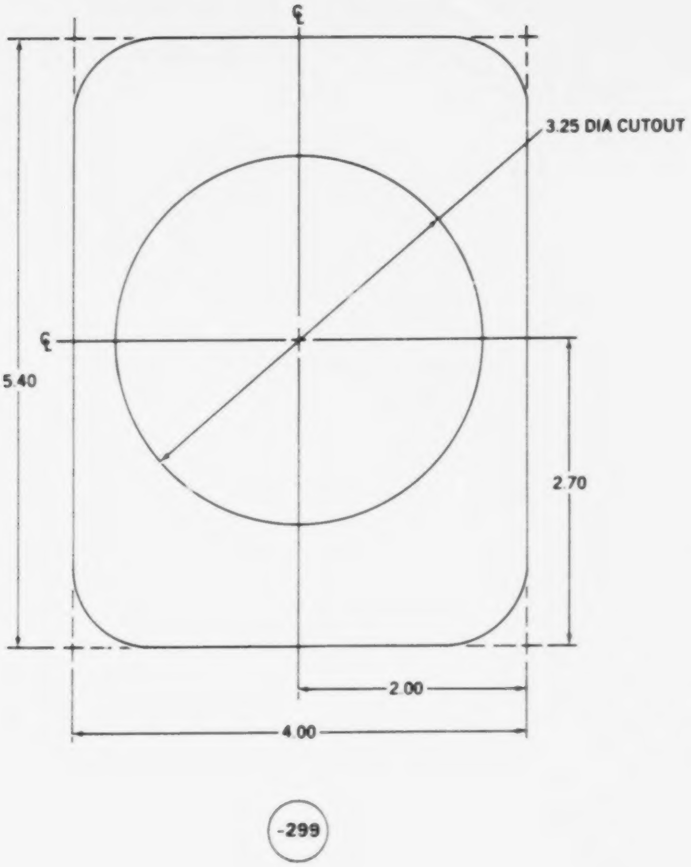
FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 54 OF 57)


4.30
5.44
4.40
0.37R (TYP)
3.20

-295

S 79715 55 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 55 OF 57)



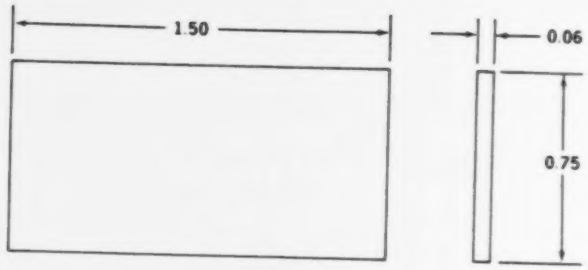
S 79715 56 (C18)

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 56 OF 57)

NOTES:

1. MAKE FROM DAMPING FOIL, SJ2017X, NSN 1560-01-184-1735.
2. ALL DIMENSIONS ARE IN INCHES.
3. CUT DAMPING FOIL TO RECTANGULAR DIMENSIONS.
4. MEASURE AND MARK FINAL DIMENSIONS ON FOIL.
5. TRIM TO REQUIRED SIZE. ROUND OFF CORNERS TO PREVENT DELAMINATION. MINIMUM RADIUS IS 0.28 INCH.
6. IDENTIFY PARTS PER MIL-STD-130.
7. DASH NUMBERS SHOWN ARE TAKEN FROM SIKORSKY DRAWING, NUMBER 70500-02066, DAMPING INSTL - SOUND-ABSORBING.

FIGURE H-171. FOIL PANEL (SOUND-ABSORBING) - UNUSUAL CONFIGURATION (SHEET 57 OF 57)



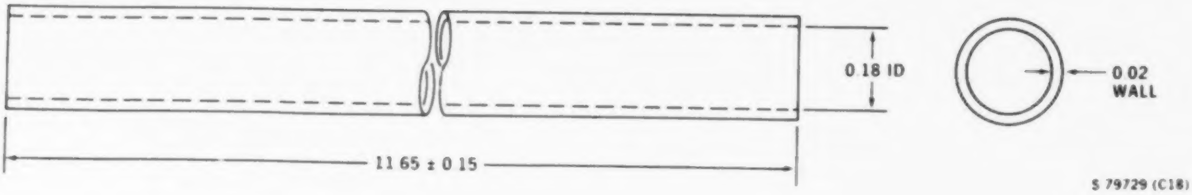
S 79718 (C18)

NOTES:
1. MAKE FROM 0.06-INCH-THICK, CLASS 2, GRADE 60 RUBBER, MIL-R-6855, NSN 9320-01-157-9070.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-190. STAMP OR STENCIL PART NUMBER AND DATE OF MANUFACTURE ON PARTS WITH OPAQUE GREEN INK, TT-I-1795. USE 1/16 - 1/8-INCH HIGH SANS SERIF CHARACTERS.

EXAMPLE: $\underbrace{\text{P/N 70216-02401-107}}_{\text{PART NUMBER}}$ $\underbrace{\text{3Q}}_{\text{THIRD QUARTER}}$ $\underbrace{\text{86}}_{\text{1986}}$

PART NUMBER: 70212-02139-106 UPPER FUSELAGE GASKET.

FIGURE H-172. UPPER FUSELAGE GASKET

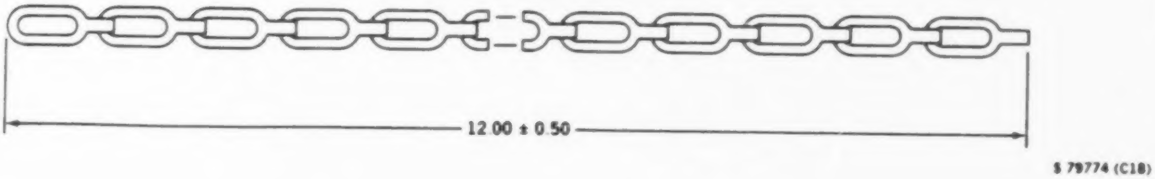


PART NUMBER	MAKE FROM	NSN
2652559-1	M23053/5-105-C	5970-01-132-9963

NOTES:
1. CUT TUBING TO LENGTH PER FIGURE, USING MATERIAL LISTED IN CHART.
2. ALL DIMENSIONS ARE IN INCHES.
3. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 2652559-1 CHAIN ASSEMBLY TUBING.

FIGURE H-173. CHAIN ASSEMBLY TUBING



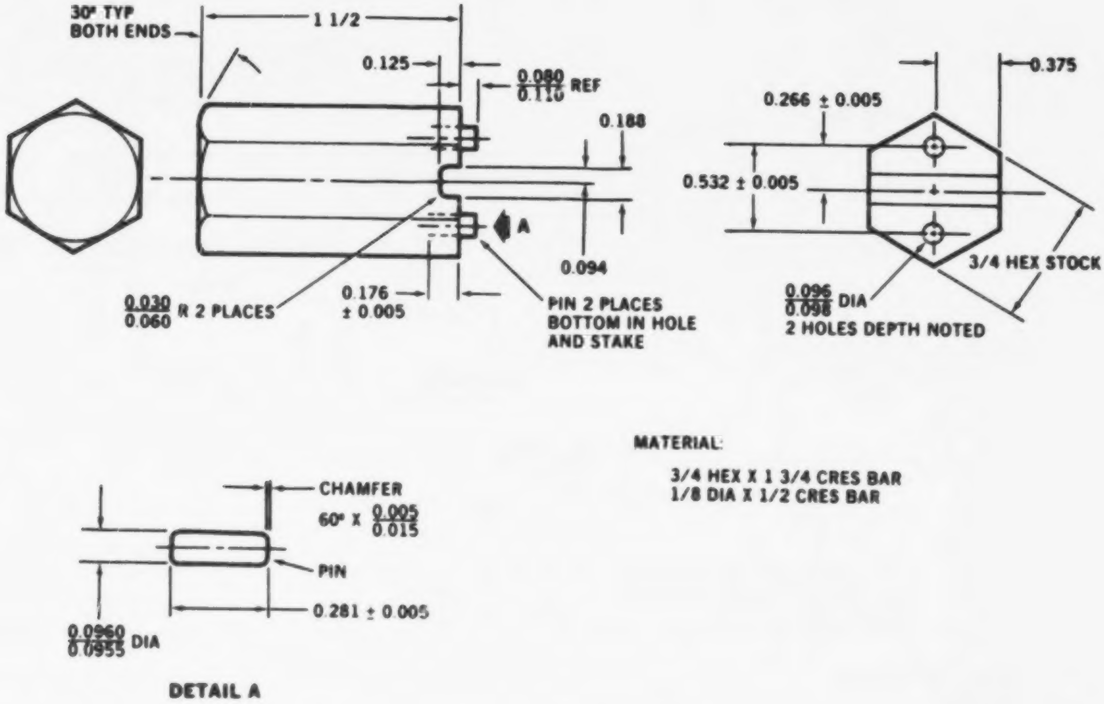
NOTES:
1. MAKE FROM NO. 00 STEEL WELDLESS SAFETY CHAIN, RR-C-271, TYPE II, CLASS 2, FSCM 81348.
2. ALL DIMENSIONS ARE IN INCHES.
3. CUT CHAIN TO REQUIRED LENGTH PER FIGURE.
4. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 1427-566558 SAFETY CHAIN.

FIGURE H-174. SAFETY CHAIN

NOTE

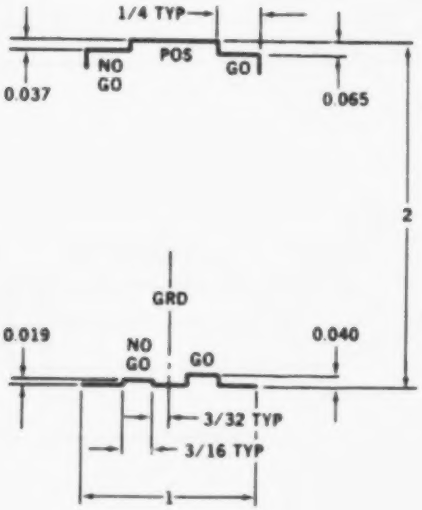
ALL DIMENSIONS ARE IN INCHES
UNLESS NOTED OTHERWISE


30° TYP
BOTH ENDS
1 1/2
0.125
0.080/0.110 REF
0.188
A
0.094
0.176 ± 0.005
0.030/0.060 R 2 PLACES
PIN 2 PLACES
BOTTOM IN HOLE
AND STAKE
0.266 ± 0.005
0.375
0.532 ± 0.005
3/4 HEX STOCK
0.096/0.098 DIA
2 HOLES DEPTH NOTED
CHAMFER
60° X 0.005/0.015
PIN
0.281 ± 0.005
0.0960/0.0955 DIA
DETAIL A

MATERIAL:

3/4 HEX X 1 3/4 CRES BAR
1/8 DIA X 1/2 CRES BAR

BREECH CAP PLUG ASSEMBLY WRENCH


1/4 TYP
NO GO
POS
GO
0.037
0.065
2
GRD
0.019
NO GO
GO
0.040
3/32 TYP
3/16 TYP
1

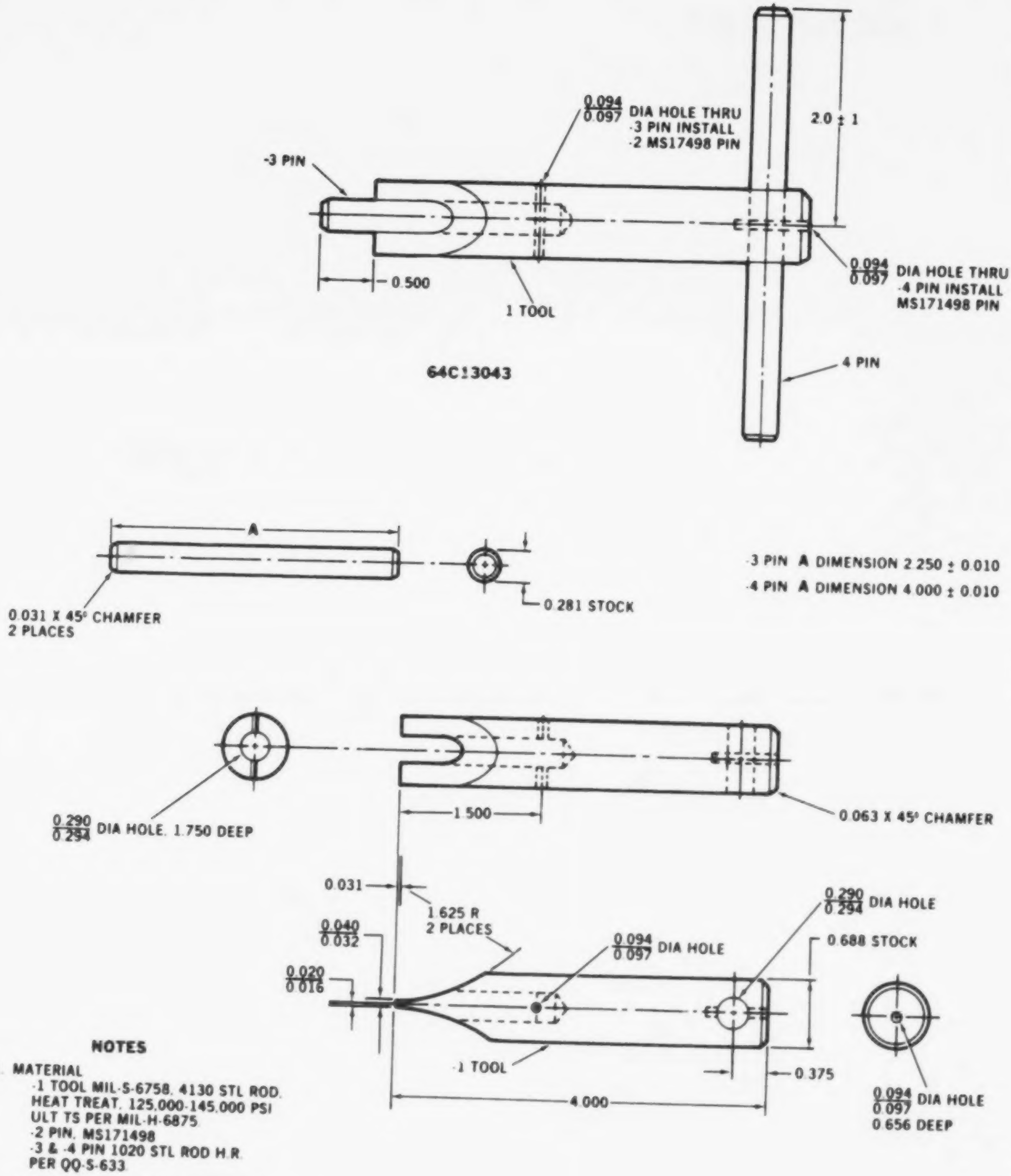
MATERIAL:

SAE 4130 STEEL OR EQUIVALENT 0.060-0.095. USE 1/8 INCH STEEL STENCIL FOR LETTERS.

GO-NO-GO BREECH CAP GAGE

S 98740 (C39)

FIGURE H-175.

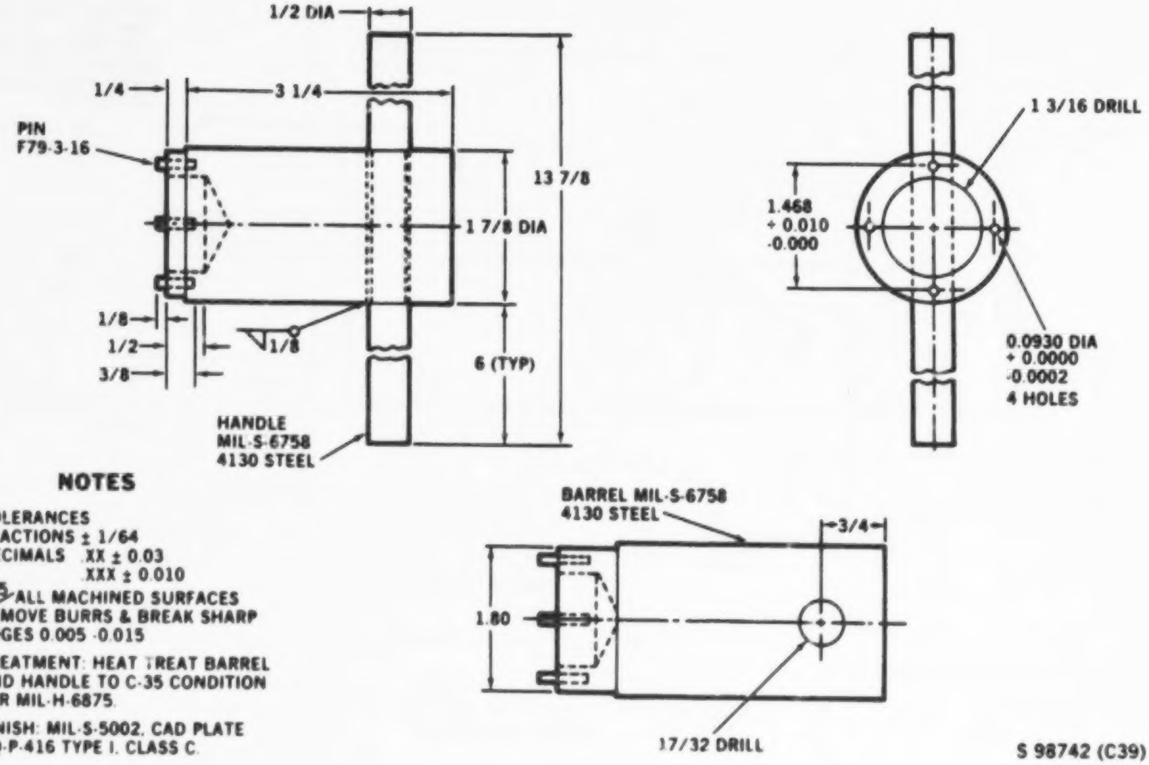

0.094/0.097 DIA HOLE THRU
-3 PIN INSTALL
-2 MS17498 PIN
2.0 ± 1
-3 PIN
0.500
1 TOOL
0.094/0.097 DIA HOLE THRU
-4 PIN INSTALL
MS171498 PIN
4 PIN
64C13043
A
0.031 X 45° CHAMFER
2 PLACES
0.281 STOCK
-3 PIN A DIMENSION 2.250 ± 0.010
-4 PIN A DIMENSION 4.000 ± 0.010
0.290/0.294 DIA HOLE, 1.750 DEEP
1.500
0.063 X 45° CHAMFER
0.031
1.625 R
2 PLACES
0.040/0.032
0.020/0.016
0.094/0.097 DIA HOLE
0.290/0.294 DIA HOLE
0.688 STOCK
-1 TOOL
0.375
4.000
0.094/0.097 DIA HOLE
0.656 DEEP

NOTES

1. MATERIAL
   -1 TOOL MIL-S-6758, 4130 STL ROD, HEAT TREAT, 125,000-145,000 PSI ULT TS PER MIL-H-6875.
   -2 PIN, MS171498
   -3 & -4 PIN 1020 STL ROD H.R. PER QQ-S-633.
2. -1, -3 AND -4 CAD PLATE PER QQ-P-416, TYPE 1, CLASS 3.
3. TOLERANCES ± 0.010

S 98741 (C39)

FIGURE H-176.


1/2 DIA
1/4
3 1/4
PIN
F79-3-16
13 7/8
1 7/8 DIA
1/8
1/2
3/8
1/8
6 (TYP)
HANDLE
MIL-S-6758
4130 STEEL
1 3/16 DRILL
1.468
+ 0.010
-0.000
0.0930 DIA
+ 0.0000
-0.0002
4 HOLES
BARREL MIL-S-6758
4130 STEEL
3/4
1.80
17/32 DRILL

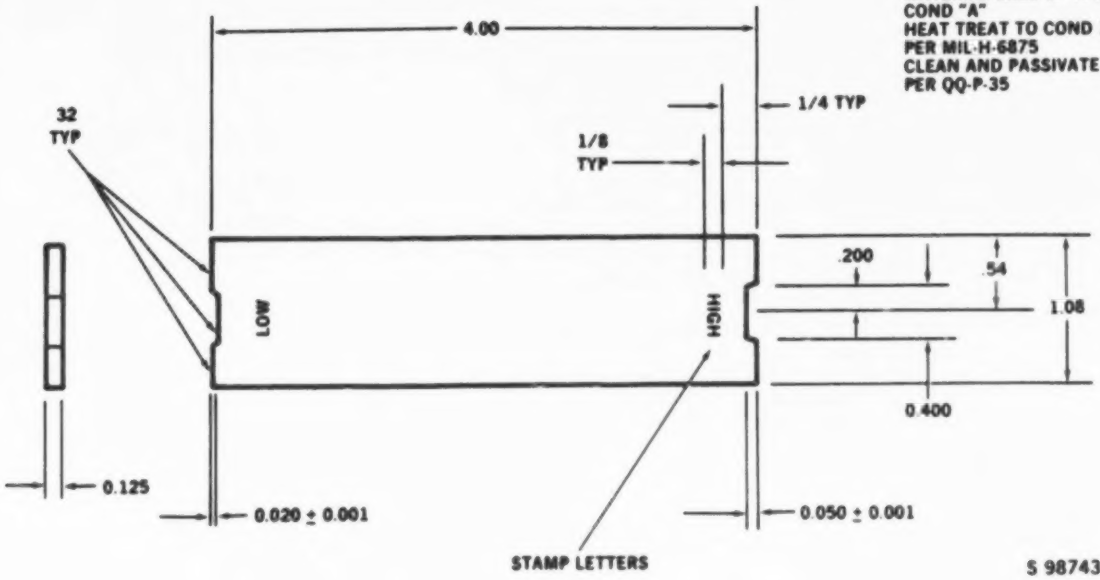
NOTES

1. TOLERANCES
   FRACTIONS ± 1/64
   DECIMALS .XX ± 0.03
   .XXX ± 0.010
   125 ALL MACHINED SURFACES
   REMOVE BURRS & BREAK SHARP EDGES 0.005 -0.015
2. TREATMENT: HEAT TREAT BARREL AND HANDLE TO C-35 CONDITION PER MIL-H-6875.
3. FINISH: MIL-S-5002. CAD PLATE QQ-P-416 TYPE I, CLASS C.

S 98742 (C39)

FIGURE H-177.

MATERIAL CRES 17-4PH
COND "A"
HEAT TREAT TO COND 11925
PER MIL-H-6875
CLEAN AND PASSIVATE
PER QQ-P-35


4.00
1/4 TYP
1/8
TYP
32
TYP
LOW
HIGH
.200
.54
1.08
0.400
0.125
0.020 ± 0.001
0.050 ± 0.001
STAMP LETTERS

S 98743 (C39)

FIGURE H-178.

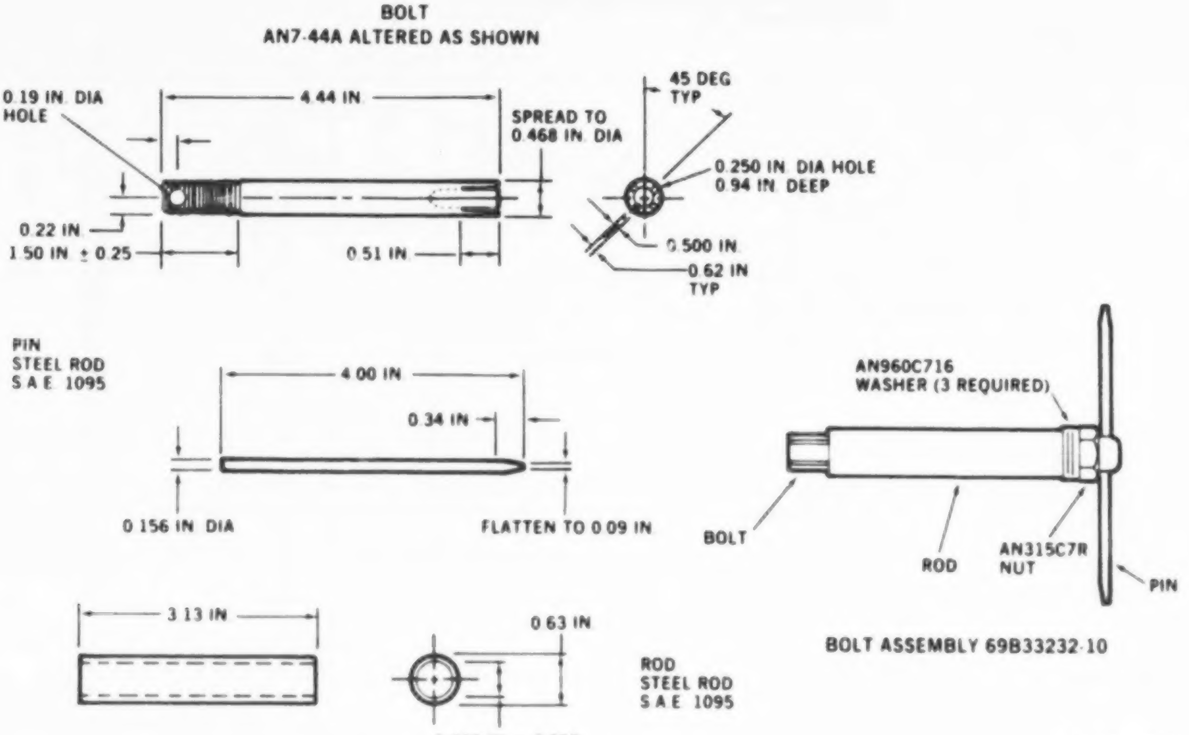

BOLT
AN7-44A ALTERED AS SHOWN
0.19 IN. DIA
HOLE
4.44 IN.
SPREAD TO
0.468 IN. DIA
45 DEG
TYP
0.250 IN. DIA HOLE
0.94 IN. DEEP
0.22 IN.
1.50 IN. ± 0.25
0.51 IN.
0.500 IN.
0.62 IN
TYP
PIN
STEEL ROD
S.A.E. 1095
4.00 IN
0.34 IN
0.156 IN. DIA
FLATTEN TO 0.09 IN
AN960C716
WASHER (3 REQUIRED)
BOLT
ROD
AN315C7R
NUT
PIN
BOLT ASSEMBLY 69B33232-10
3.13 IN
0.63 IN
ROD
STEEL ROD
S.A.E. 1095
0.442 IN. ± 0.003

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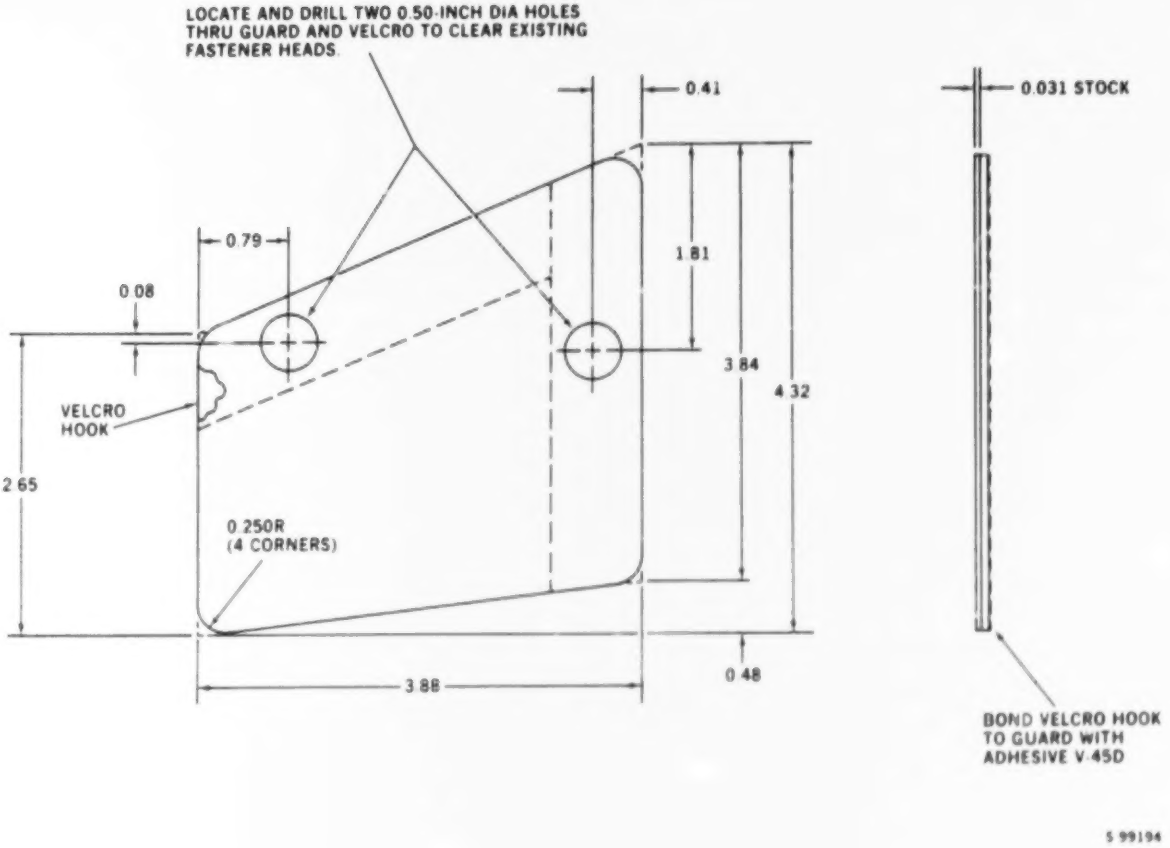
FIGURE H-179.

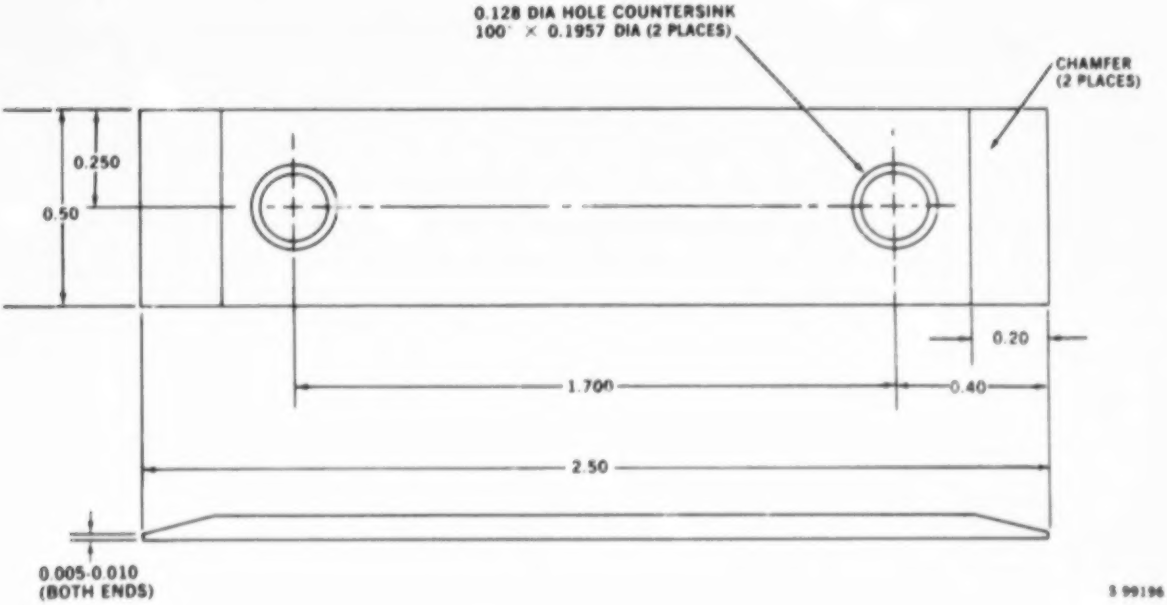

LOCATE AND DRILL TWO 0.50-INCH DIA HOLES THRU GUARD AND VELCRO TO CLEAR EXISTING FASTENER HEADS.
0.41
0.031 STOCK
0.79
0.08
1.81
3.84
4.32
VELCRO HOOK
2.65
0.250R (4 CORNERS)
3.88
0.48
BOND VELCRO HOOK TO GUARD WITH ADHESIVE V-45D
S 99194

NOTES:

1. MAKE FROM CLEAR ACRYLIC PLASTIC SHEET, MIL-P-46144, TYPE I, GRADE A, 0.031-INCH THICK, NSN 9330-01-191-5002.
2. BOND VELCRO HOOK TAPE TO GUARD WITH ADHESIVE, V45D, NSN 8040-01-203-8976.
3. ALL DIMENSIONS ARE IN INCHES.
4. IDENTIFY PARTS PER MIL-STD-130.
5. REMOVE BURRS AND SHARP EDGES.
6. USE 0.50-INCH WIDE VELCRO HOOK, NSN 8315-01-213-9560.

PART NUMBER: 70217-02708-051.

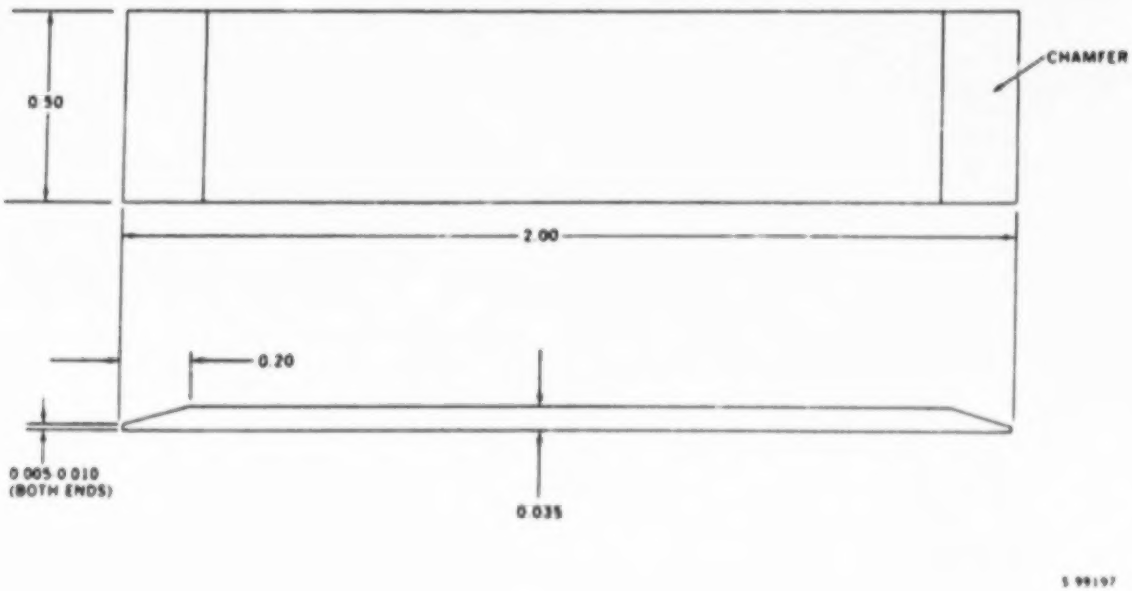
FIGURE H-180. JETTISON HANDLE GUARD


0.128 DIA HOLE COUNTERSINK
100° × 0.1957 DIA (2 PLACES)
CHAMFER
(2 PLACES)
0.250
0.50
0.20
1.700
0.40
2.50
0.005-0.010
(BOTH ENDS)
3 99196

NOTES:
1. MAKE FROM STAINLESS STEEL, MIL-S-5059, 301 1/2 HARD, 0.036-INCH THICK, NSN 9515-00-232-7779.
2. ALL DIMENSIONS ARE IN INCHES.
3. INSULATE DISSIMILAR METALS ON INSTALLATION (TM 55-1500-204-25/1).
4. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 70207-02727-125 WEAR STRIP.

FIGURE H-181. WEAR STRIP

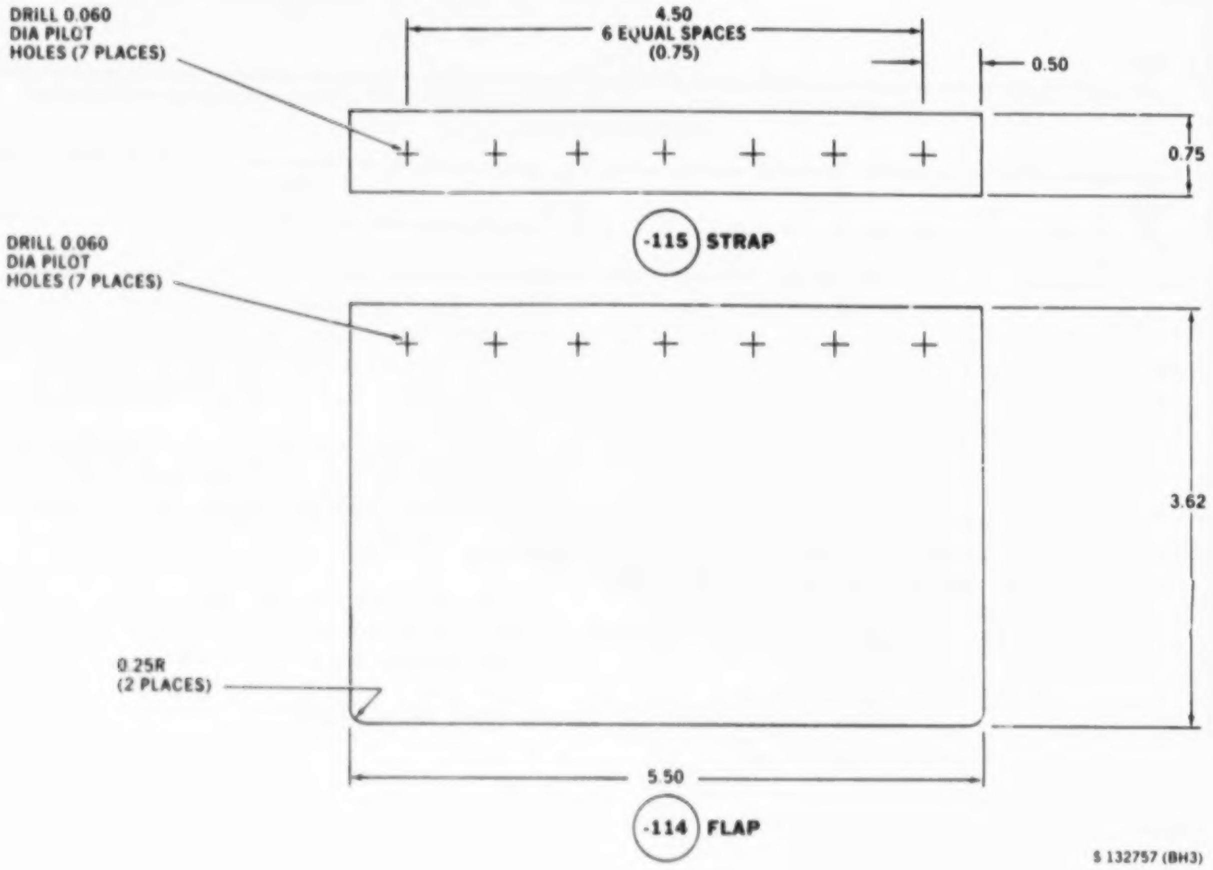

0.50
CHAMFER
2.00
0.20
0.005 0.010
(BOTH ENDS)
0.035
S 99197

NOTES

1. MAKE FROM STAINLESS STEEL, MIL-S-5059, 301 1/2 HARD, 0.036-INCH THICK, NSN 9515-00-232-7779.
2. ALL DIMENSIONS ARE IN INCHES.
3. INSULATE DISSIMILAR METALS ON INSTALLATION.
4. IDENTIFY PARTS PER MIL-STD-130.

PART NUMBER: 70207-02727-120 WEAR STRIP.

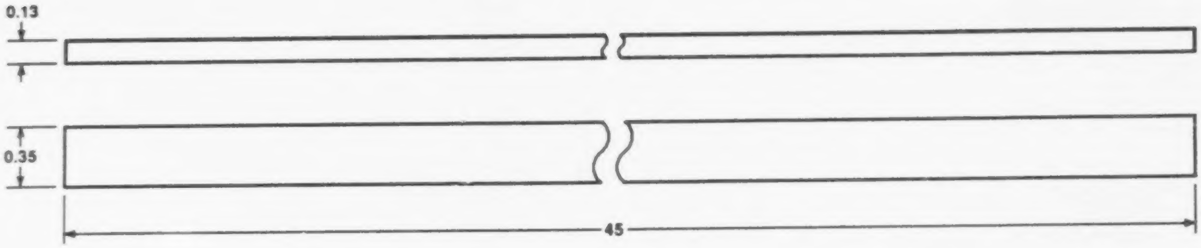
FIGURE H-182. WEAR STRIP


DRILL 0.060
DIA PILOT
HOLES (7 PLACES)
4.50
6 EQUAL SPACES
(0.75)
0.50
0.75
-115 STRAP
DRILL 0.060
DIA PILOT
HOLES (7 PLACES)
3.62
0.25R
(2 PLACES)
5.50
-114 FLAP
S 132757 (BH3)

NOTES:
1. MAKE 70205-06052-114 FROM 0.040 THICK ALUMINUM SHEET, MIL-P-4060, 05-227-009.
2. MAKE 70205-06052-115 FROM 0.040 THICK ALUMINUM SHEET, QQ-A-250-13, 7075-T6.
3. ALL DIMENSIONS ARE IN INCHES.

PART NUMBER: 70205-06052-114 FLAP.
PART NUMBER: 70205-06052-115 STRAP.

FIGURE H-183. HAND HOLD FLAP AND STRAP



UH60A_151460 (BH6)
SA

NOTES:
1. MAKE FROM MIL-R-6855, TYPE 1, GRADE 40, .13 THK.
2. ALL DIMENSIONS ARE IN INCHES.

PART NUMBER: 70215-05002-131 STRIP.

FIGURE H-184. STRIP, TAIL ROTOR DRIVE SHAFT COVER

GLOSSARY

A

ACCESS - This is a means of getting into a part of the helicopter. Doors allow one access or entry. However, many panels (access panels) are designed as removable covers that allow personnel to get to areas otherwise concealed, to do required tasks.

ANEMOSTAT - An adjustable opening in the heating/ventilating ducts that is used to control airflow into the cockpit and cabin of the helicopter.

ATTACHING COMPONENTS - Parts that are attached to a larger assembly, such as a gear box, and which must be removed in order to isolate the larger assembly.

B

BIM ® - Blade inspection method

BLOCK DIAGRAM - A figure that shows by means of blocks, representing pieces of equipment or systems, how components tie in to one another.

BREAKING TORQUE - To gradually reduce, by loosening, the tension on an attaching device, such as a bolt and nut.

BUILDUP - The reverse of TEARDOWN. It is the installation onto a larger component or assembly, of lines, wiring, supports, and other parts, so that the larger component or assembly remains, for shipping or storage.

C

CALIBRATE - To adjust the operation of a piece of equipment so that it will operate within certain specified limits.

CENTERLINE - An imaginary line through the middle of a designated area, from which a measurement is to be taken.

CHECK - Usually used to indicate that an examination is to be made for condition or workability, and that one's senses will be used (looking, feeling, hearing, smelling).

E

ENABLE - To make it possible for a piece of electronic equipment to operate, usually by putting a controlling switch ON.

ESU - Electronic Sequence Unit

F

FAULT DISABLE - When a fault develops in certain equipment the component will turn itself off to prevent further damage.

FAULT ISOLATION PROCEDURE - A procedure that is followed to correct malfunctions in equipment.

FUNCTION - The job that a piece of equipment does either by itself, or working in combination with other equipment.

I

INSPECT - Usually used to indicate that an examination is to be made for condition or workability, and that equipment, such as instruments and/or tools, will be used.

J

JACKSCREW - Screws that are used to separate parts. Each jackscrew used is turned a small amount, until the parts gradually separate.

L

LEFT-HAND THREAD - A thread that spirals to the left, as opposed to a standard right-hand thread, that spirals to the right. A left-hand thread is typically used on some control rods and onturnbuckles, opposing a right-hand thread on the opposite end.

LOCATION DIAGRAM - An illustration that shows various assemblies involved in a particular configuration, in their normal location on the helicopter.

LOGIC TYPE TROUBLESHOOTING CHART - A chart that states a problem that has caused a component to malfunction, and then gives step-by-step instructions, in outlined rectangles, that will discover the cause of the malfunction and tell how to eliminate the problem or repair the component.

M

MAINTENANCE - One or more of a number of actions on the helicopter done to make sure that it is kept in good flying condition. This includes many procedures related to systems and components, including: removal, replacement, inspection, checking, adjustment, testing, repair, lubrication, installation, servicing.

OPERATIONAL CHECK - Where required, it is a procedure that follows a maintenance action on an assembly, and precedes the in-flight use of that assembly. It is done to be sure that the component is in proper working condition.

R

REMOVE SLACK - To adjust so that there is no looseness, such as with a pulley belt. Where there is more than one element involved, as with the cables of a sling, slack must be removed uniformly from all elements.

ROTATE - To turn on a fixed axis. However, this concerns successive turnings of 360°. You can manually turn a rotor head. An operating rotor head rotates. Likewise, a control switch that turns around a central axis is turned by the operator, not rotated.

T

TEARDOWN - The reverse of BUILDUP. It is the removal, from a larger component or assembly, of lines, hoses, wiring, supports, and other parts, so that the larger component or assembly, as originally received from shipping or storage, remains.

THEORY OF OPERATION - A description of a system, or a part of that system, telling how things work, hydraulically, electrically, and mechanically.

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The Metric System and Equivalents

Linear Measure

1 centimeter = 10 millimeters = .39 inch
1 decimeter = 10 centimeters = 3.94 inches
1 meter = 10 decimeters = 39.37 inches
1 dekameter = 10 meters = 32.8 feet
1 hectometer = 10 dekameters = 328.08 feet
1 kilometer = 10 hectometers = 3,280.8 feet

Weights

1 centigram = 10 milligrams = .15 grain
1 decigram = 10 centigrams = 1.54 grains
1 gram = 10 decigram = .035 ounce
1 dekagram = 10 grams = .35 ounce
1 hectogram = 10 dekagrams = 3.52 ounces
1 kilogram = 10 hectograms = 2.2 pounds
1 quintal = 100 kilograms = 220.46 pounds
1 metric ton = 10 quintals = 1.1 short tons

Liquid Measure

1 centiliter = 10 milliters = .34 fl. ounce
1 deciliter = 10 centiliters = 3.38 fl. ounces
1 liter = 10 deciliters = 33.81 fl. ounces
1 dekaliter = 10 liters = 2.64 gallons
1 hectoliter = 10 dekaliters = 26.42 gallons
1 kiloliter = 10 hectoliters = 264.18 gallons

Square Measure

1 sq. centimeter = 100 sq. millimeters = .155 sq. inch
1 sq. decimeter = 100 sq. centimeters = 15.5 sq. inches
1 sq. meter (centare) = 100 sq. decimeters = 10.76 sq. feet
1 sq. dekameter (are) = 100 sq. meters = 1,076.4 sq. feet
1 sq. hectometer (hectare) = 100 sq. dekameters = 2.47 acres
1 sq. kilometer = 100 sq. hectometers = .386 sq. mile

Cubic Measure

1 cu. centimeter = 1000 cu. millimeters = .06 cu. inch
1 cu. decimeter = 1000 cu. centimeters = 61.02 cu. inches
1 cu. meter = 1000 cu. decimeters = 35.31 cu. feet

Approximate Conversion Factors

To change	*To*	*Multiply by*	*To change*	*To*	*Multiply by*
inches	centimeters	2.540	ounce-inches	newton-meters	.007062
feet	meters	.305	centimeters	inches	.394
yards	meters	.914	meters	feet	3.280
miles	kilometers	1.609	meters	yards	1.094
square inches	square centimeters	6.451	kilometers	miles	.621
square feet	square meters	.093	square centimeters	square inches	.155
square yards	square meters	.836	square meters	square feet	10.764
square miles	square kilometers	2.590	square meters	square yards	1.196
acres	square hectometers	.405	square kilometers	square miles	.386
cubic feet	cubic meters	.028	square hectometers	acres	2.471
cubic yards	cubic meters	.765	cubic meters	cubic feet	35.315
fluid ounces	milliliters	29.573	cubic meters	cubic yards	1.308
pints	liters	.473	milliliters	fluid ounces	.034
quarts	liters	.946	liters	pints	2.113
gallons	liters	3.785	liters	quarts	1.057
ounces	grams	28.349	liters	gallons	.264
pounds	kilograms	.454	grams	ounces	.035
short tons	metric tons	.907	kilograms	pounds	2.205
pound-feet	newton-meters	1.356	metric tons	short tons	1.102
pound-inches	newton-meters	.11296			

Temperature (Exact)

°F	Fahrenheit temperature	5/9 (after subtracting 32)	Celsius temperature	°C